

SPECIFICATION

Docket No. 291H-24527

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TO ALL WHOM IT MAY CONCERN:

BE IT KNOWN that I, Daniel R. Joseph, a citizen of the United States of America, residing in the City of Dallas, Texas, have invented new and useful improvements in a

IMPROVED METHOD AND APPARATUS FOR AUTOMATICALLY BALANCING A BLOWER IN ANY BLOWN FILM EXTRUSION LINE

Small

of which the following is a specification:

BACKGROUND OF THE INVENTION

1. Cross Reference to Related Application:

This patent application includes a disclosure which, in large portion, is similar to the disclosure in United States Patent Application Serial No. 08/658,369, entitled "*Method and Apparatus for Cooling Extruded Film Tubes*", which was filed on June 5, 1996. However, this application is not a continuation or continuation-in-part of this co-pending application.

2. Field of the Invention:

This invention relates generally to blown film extrusion lines, and specifically to operations of the inlet and outlet blowers of blown film systems.

3. Description of the Prior Art:

Blown film extrusion lines are used to manufacture plastic bags and plastic sheets. A molten tube of plastic is extruded from an annular die, and then stretched and expanded to a larger diameter and a reduced radial thickness by the action of overhead nip rollers and internal air pressure. Typically, air is entrained by one or more blowers to provide a cooling medium which absorbs heat from the molten material and speeds up the change in state from a molten material back to a solid material. Additionally, blowers are used to provide air pressure which is utilized to control the size and thickness of the film tube. One type of blown film extrusion line utilizes an air flow on the exterior surface of the film tube in order to absorb heat. A different, and more modern, type of blown film extrusion line utilizes both an external flow of cooling air and an internal flow of cooling air in order to cool and size the film tube.

As stated above, blowers are utilized to provide air to the interior of the film tube. Typically, a supply blower is provided in order to supply air

1 to the interior of the film tube, and an exhaust blower is provided in order to
2 exhaust air from the interior of the film tube. Typically, the supply blower and
3 exhaust blower are under electrical control during production operations.
4 However, during startup of the extrusion process, in the prior art, a great deal
5 of human intervention is required in order to establish the bubble. Typically,
6 a human operator will first control the supply blower until the extruded film
7 tube is closed at its upper end by engagement with the overhead nip rollers.
8 Then, the exhaust blowers utilized to remove air in order to prevent expan-
9 sion and eventual breaking of the extruded film tube. A balance between the
10 supply blower and the exhaust blower must be obtained in order to allow for
11 continuous production of the extruded film tube. The startup of an extruded
12 film is a relatively difficult operation to perform, and generally requires a
13 relatively highly-skilled employee to oversee or perform the startup
14 operations.

SUMMARY OF THE INVENTION

It is one objection of the present invention to provide a method and apparatus for startup of an extruded film tube which includes a supply blower, an exhaust blower, and a controller member, including executable program instructions which define at least one control routine for automatic and coordinated control of the supply blower and the exhaust blower during startup.

The control routines may comprise a startup routine which is utilized in initiating the extruded film tube, a blower optimization routine which is utilized to optimize the operating speeds of either or both of the supply blower and the exhaust blower, and a valve optimization routine wherein an operating condition is established for either or both of the supply blower and the exhaust blower in a manner which optimizes operation of a valve member which is utilized to control the application of air from the supply blower to the extruded film tube.

It is yet another objective of the present invention to utilize prior recorded operating conditions for either or both of the supply blower and exhaust blower in order to take advantage of the value of prior experience with a particular blown film line.

It is yet another objective of the present invention to provide an additional routine which can be utilized to detect bubble breaks during and after the startup operations.

These and other objectives are achieved as is now described.

A method and apparatus is provided for startup of an extruded film tube. The method and apparatus is used in a blown film extrusion appa-

1 ratus in which film is extruded as a tube from an annular die and pulled along
2 a predetermined path. A means is provided for varying a quantity of air within
3 the extruded film tube. Preferably, the means includes a supply blower which
4 supplies air to the extruded film tube in an amount corresponding to a supply
5 control signal, and an exhaust blower which exhausts air from the extruded
6 film tube in an amount corresponding to an exhaust control signal. A control-
7 ler member is provided. The controller member includes executable program
8 instructions which define at least one control routine for automatic and
9 coordinated control of the means for varying during startup of the extruded
10 film tube. The controller directs a series of supply control signals to the sup-
11 ply blower and exhaust control signals to the exhaust blower in order to set
12 their optimum operating conditions. In the preferred embodiment, a control
13 interface is provided for receiving operator instructions during startup of the
14 extruded film tube. The controller further includes program instructions for
15 receiving the operating instructions and integrating the operating instructions
16 into the at least one control routine. In the preferred embodiment, a valve
17 member is provided between the supply blower and the extruded film tube.
18 The valve member is under control of the controller member, and is utilized
19 for varying admission of air into the extruded film tube and for controlling the
20 circumference of the extruded film tube after startup of the extruded film tube.

21
22 In the preferred embodiment, a variety of control routines may
23 be provided. In a startup routine, the controller member initiates operation of
24 the supply blower and the exhaust blower by first initiating operation of the
25 supply blower in accordance with at least one predetermined operating para-
26 meter, and then initiating the exhaust blower in accordance with at least one
27 predetermined parameter.

28
29 In a blower optimization routine, at least one of the supply
30 control signal and the exhaust control signal is determined, at least in part,
31 from at least one prior recorded control signal. Preferably, a table is

1 generated in controller memory which records over time the optimum settings
2 of the supply blower and exhaust blower. During startup, the blower optimi-
3 zation routine may be utilized to take advantage of the prior historical know-
4 ledge of the blown film apparatus.

5
6 In a valve optimization routine, an operating condition is
7 established for at least one of the supply blower and the exhaust blower in
8 a manner which optimizes operation of the valve member. In the preferred
9 embodiment of the present invention, the objective is to allow the valve
10 member to operate in a preferred and substantially linear range of closure
11 conditions.

12
13 In a bubble break detection routine, a position signal (which
14 indicates the position or size of the bubble) is utilized in combination with at
15 least one software timer in order to detect a break in the extruded film tube.
16 In the preferred embodiment of the present invention, one software timer is
17 utilized to suppress operation of the bubble break detection routine until a
18 portion of the startup routine is completed. Then, a second software timer is
19 utilized in order to identify unacceptably long intervals of interruption in the
20 position signal, which is interpreted to identify a break or collapse of the
21 extruded film tube.

BRIEF DESCRIPTION OF THE DRAWINGS

The novel features believed characteristic of the invention are set forth in the appended claims. The invention itself however, as well as a preferred mode of use, further objects and advantages thereof, will best be understood by reference to the following detailed description of an illustrative embodiment when read in conjunction with the accompanying drawings, wherein:

Figure 1 is a view of a blown film extrusion line equipped with the improved control system of the present invention;

Figure 2 is a view of the die, sizing cage, control subassembly and rotating frame of the blown film tower of **Figure 1**;

Figure 3 is a view of the acoustic transducer of the improved control system of the present invention coupled to the sizing cage of the blown film extrusion line tower adjacent the extruded film tube of Figures 1 and 2;

Figure 4 is a view of the acoustic transducer of Figure 3 coupled to the sizing cage of the blown film tower, in two positions, one position being shown in phantom;

Figure 5 is a schematic and block diagram view of the preferred control system of the present invention;

Figure 6 is a schematic and block diagram view of the preferred control system of **Figure 5**, with special emphasis on the supervisory control unit;

1 **Figure 7A** is a schematic and block diagram view of the signals
2 generated by the ultrasonic sensor which pertain to the position of the blown
3 film layer;

4
5 **Figure 7B** is a view of the ultrasonic sensor of **Figure 3** coupled
6 to the sizing cage of the blown film tower, with permissible extruded film tube
7 operating ranges indicated thereon;

8
9 **Figure 8A** is a flow chart of the preferred filtering process
10 applied to the current position signal generated by the acoustic transducer;

11
12 **Figure 8B** is a graphic depiction of the operation of the filtering
13 system;

14
15 **Figure 9** is a schematic representation of the automatic sizing
16 and recovery logic (ASRL) of **Figure 6**;

17
18 **Figure 10** is a schematic representation of the health/state logic
19 (HSL) of **Figure 6**;

20
21 **Figure 11** is a schematic representation of the loop mode
22 control logic (LMCL) of **Figure 6**;

23
24 **Figure 12** is a schematic representation of the volume setpoint
25 control logic (VSCL) of **Figure 6**;

26
27 **Figure 13** is a flow chart representation of the output clamp of
28 **Figure 6**.

29
30 **Figure 14** is a schematic and block diagram, and flowchart
31 views of the preferred alternative emergency condition control system of the

1 present invention, which provides enhanced control capabilities for detected
2 overblown and underblown conditions, as well as when the control system
3 determines that the extruded film tube has passed out of range of the sensing
4 transducer;

5
6 **Figure 15** is a schematic and block diagram view of the signals
7 generated by the ultrasonic sensor which pertain to the position of the blown
8 film layer;

9
10 **Figure 16** is a view of the ultrasonic sensor of **Figure 3** coupled
11 to the sizing cage of the blown film tower, with permissible extruded film tube
12 operating ranges indicated thereon;

13
14 **Figure 17** is a schematic representation of the automatic sizing
15 and recovery logic (ASRL) of **Figure 14**;

16
17 **Figure 18** is a schematic representation of the health/state logic
18 (HSL) of **Figure 14**;

19
20 **Figure 19** is a schematic representation of the loop mode
21 control logic (LMCL) of **Figure 14**;

22
23 **Figure 20** is a schematic representation of the volume setpoint
24 control logic (VSCL) of **Figure 14**;

25
26 **Figure 21** is a flow chart representation of the output clamp of
27 **Figure 14**;

28
29 **Figure 22** is a schematic and block diagram view of emergency
30 condition control logic block of **Figure 14**;

1 **Figures 23A through 23G** depict the preferred software routines
2 utilized in the present invention, including a first filter routine which is utilized
3 during relatively unstable intervals of operation, and a second dynamic filter-
4 ing routine which is utilized during relatively stable intervals of operation;

5
6 **Figure 24** is a graphic depiction of the normal operation of the
7 filtering system;

8
9 **Figure 25A** is a graph which depicts the emergency condition
10 control mode of operation response to the detection of an underblown condi-
11 tion, with the X-axis representing time and the Y-axis representing position
12 of the extruded film tube;

13
14 **Figure 25B** is a graph of the binary condition of selected
15 operating blocks of the block diagram depiction of **Figure 22**, and can be
16 read in combination with **Figure 25A**, wherein the X-axis represents time, and
17 the Y-axis represents the binary condition of selected operational blocks;

18
19 **Figure 26A** is a graph which depicts the emergency condition
20 control mode of operation response to the detection of an underblown condi-
21 tion, with the X-axis representing time and the Y-axis representing position
22 of the extruded film tube;

23
24 **Figure 26B** is a graph of the binary condition of selected
25 operating blocks of the block diagram depiction of **Figure 22**, and can be
26 read in combination with **Figure 26A**, wherein the X-axis represents time, and
27 the Y-axis represents the binary condition of selected operational blocks;

28
29 **Figure 27A** is a graph which depicts the emergency condition
30 control mode of operation response to the detection of an underblown condi-

tion, with the X-axis representing time and the Y-axis representing position of the extruded film tube;

Figure 27B is a graph of the binary condition of selected operating blocks of the block diagram depiction of **Figure 22**, and can be read in combination with **Figure 27A**, wherein the X-axis represents time, and the Y-axis represents the binary condition of selected operational blocks;

Figure 28 is a schematic and block diagram depiction of one embodiment of the improved air flow control system of the present invention;

Figure 29 is a simplified and partial fragmentary and longitudinal section view of the preferred air flow control device used with the air flow control system of the present invention;

Figure 30 is a schematic depiction of a IBC blown film extrusion line equipped with mass air flow sensors in communication with both a supply of cooling air and an exhaust of cooling air, which may be utilized to obtain uniformity in the mass air flow of the cooling air stream supply to the interior of the blown film tube;

Figure 31 is a schematic depiction of an IBC blown film line equipped with mass air flow sensors for controlling the supply and exhaust of air to the interior of the blown film tube, and additionally equipped with a mass air flow sensor for monitoring and controlling the supply of external cooling air;

Figures 32, 33, 34, and 35 are schematic depictions of an external cooling air system for a blown film extrusion line, with a mass air flow sensor provided to allow control over an adjustable air flow attribute modifier;

1 **Figure 36** is a flowchart representation of computer program
2 implemented operations for achieving a feedback control loop for a blown film
3 system;

4
5 **Figure 37A** is a schematic representation of the prior art control
6 of supply and exhaust blowers;

7
8 **Figure 37B** and **Figure 37C** are graphical representations of the
9 performance curves for supply and exhaust blowers;

10
11 **Figure 37D** is a block diagram and schematic representation of
12 the startup control apparatus of the present invention;

13
14 **Figure 37E** is a flowchart representation of the control routine
15 of the startup control apparatus of the present invention;

16
17 **Figure 37F(1)-37F(2)** is a flowchart representation of the startup
18 mode of operation of **Figure 37E**;

19
20 **Figures 37G** through **37J** are flowchart representations of the
21 run mode of **Figure 37E**;

22
23 **Figure 37K** is a flowchart representation of the balance mode
24 of **Figure 37E**;

25
26 **Figure 37L** is a pictorial representation of an array of recorded
27 prior control settings for the supply and exhaust blowers; and

28
29 **Figure 37M** is a flowchart representation of a bubble break
30 detection routine.

DETAILED DESCRIPTION OF PREFERRED EMBODIMENT

In this detailed description of the invention, **Figures 1** through **29**, and accompanying text, provide a very detailed overview of an internal-bubble-cooling blown film extrusion system which is equipped with a preferred sizing control system. **Figures 30** through **36**, and accompanying text, provide a description of the preferred method and apparatus for cooling extruded film tubes of the present invention used either in combination with the preferred sizing control apparatus, or alone.

Figure 1 is a view of blown film extrusion line **11**, which includes a number of subassemblies which cooperate to produce plastic bags and the like from plastic resin. The main components include blown film tower **13**, which provides a rigid structure for mounting and aligning the various subassemblies, extruder subassembly **15**, die subassembly **17**, blower subassembly **19**, stack **21**, sizing cage **23**, collapsible frame **25**, nips **27**, control subassembly **28** and rollers **29**.

Plastic granules are fed into hopper **31** of extruder subassembly **15**. The plastic granules are melted and fed by extruder **33** and pushed into die subassembly **17**, and specifically to annular die **37**. The molten plastic granules emerge from annular die **37** as a molten plastic tube **39**, which expands from the die diameter to a desired final diameter, which may vary typically between two to three times the die diameter.

Blower subassembly **19** includes a variety of components which cooperate together to provide a flow of cooling air to the interior of molten plastic tube **39**, and also along the outer periphery of molten plastic tube **39**. Blower subassembly includes blower **41** which pulls air into the system at intake **43**, and exhausts air from the system at exhaust **45**. The flow of air into molten plastic tube **39** is controlled at valve **47**. Air is also directed along the exterior of molten plastic tube from external air ring **49**, which is concentric to annular die **37**. Air is supplied to the interior of molten plastic tube **39**

1 through internal air diffuser 51. Air is pulled from the interior of molten plastic
2 tube 39 by exhaust stack 53.

3 The streams of external and internal cooling airs serve to harden
4 molten plastic tube 39 a short distance from annular die 37. The line of
5 demarcation between the molten plastic tube 39 and the hardened plastic
6 tube 55 is identified in the trade as the "frost line." Normally, the frost line is
7 substantially at or about the location at which the molten plastic tube 39 is
8 expanded to the desired final diameter.

9 Adjustable sizing cage 23 is provided directly above annular die 38 and
10 serves to protect and guide the plastic tube 55 as it is drawn upward through
11 collapsible frame 25 by nips 27. Afterwards, plastic tube 55 is directed
12 through a series of rollers 57, 59, 61, and 63 which serve to guide the tube
13 to packaging or other processing equipment.

14 In some systems, rotating frame 65 is provided for rotating relative to
15 blown film tower 13. It is particularly useful in rotating mechanical feeler arms
16 of the prior art systems around plastic tube 55 to distribute the deformations.
17 Umbilical cord 67 is provided to allow electrical conductors to be routed to
18 rotating frame 65. Rotating frame 65 rotates at bearings 71, 73 relative to
19 stationary frame 69.

20 Control subassembly 28 is provided to monitor and control the
21 extrusion process, and in particular the circumference of plastic tube 55.
22 Control subassembly 28 includes supervisory control unit, and operator
23 control panel 77.

24 **Figure 2** is a more detailed view of annular die 37, sizing cage 23,
25 control subassembly 28, and rotating frame 65. As shown in **Figure 2**, super-
26 visory control unit 75 is electrically coupled to operator control panel 77, valve
27 47, and acoustic transducer 79. These components cooperate to control the
28 volume of air contained within extruded film tube 81, and hence the thickness
29 and diameter of the extruded film tube 81. Valve 47 controls the amount of
30 air directed by blower 41 into extruded film tube 81 through internal air
31 diffuser 51.

1 If more air is directed into extruded film tube **81** by internal air diffuser
2 **51** than is exhausted from extruded film tube **81** by exhaust stack **43**, the cir-
3 cumference of extruded film tube **81** will be increased. Conversely, if more
4 air is exhausted from the interior of extruded film tube **81** by exhaust stack **53**
5 than is inputted into extruded film tube **81** by internal air diffuser **51**, the
6 circumference of extruded film tube **81** will decrease.

7 In the preferred embodiment, valve **41** is responsive to supervisory
8 control unit **75** for increasing or decreasing the flow of air into extruded film
9 tube **81**. Operator control panel **77** serves to allow the operator to select the
10 diameter of extruded film tube **81**. Acoustic transducer **79** serves to generate
11 a signal corresponding to the circumference of extruded film tube **81**, and
12 direct this signal to supervisory control unit **75** for comparison to the
13 circumference setting selected by the operator at operator control panel **77**.

14 If the actual circumference of extruded film tube **81** exceeds the
15 selected circumference, supervisory control unit **75** operates valve **47** to
16 restrict the passage of air from blower **41** into extruded film tube **81**. This
17 results in a decrease in circumference of extruded film tube **81**. Conversely,
18 if the circumference of extruded film tube **81** is less than the selected
19 circumference, supervisory control unit **75** operates on valve **47** to increase
20 the flow of air into extruded film tube **81** and increase its circumference. Of
21 course, extruded film tube **81** will fluctuate in circumference, requiring
22 constant adjustment and readjustment of the inflow of air by operation of
23 supervisory control unit **75** and valve **47**.

24 **Figure 3** is a view of ultrasonic sensor **89** of the improved control
25 system of the present invention coupled to sizing cage **23** adjacent extruded
26 film tube **81**. In the preferred embodiment, acoustic transducer **79** comprises
27 an ultrasonic measuring and control system manufactured by Massa Products
28 Corporation of Hingham, Massachusetts, Model Nos. M-4000, M410/215, and
29 M450, including a Massa Products ultrasonic sensor **89**. It is an ultrasonic
30 ranging and detection device which utilizes high frequency sound waves
31 which are deflected off objects and detected. In the preferred embodiment,

1 a pair of ultrasonic sensors **89** are used, one to transmit sonic pulses, and
2 another to receive sonic pulses. For purposes of simplifying the description
3 only one ultrasonic sensor **89** is shown, and in fact a single ultrasonic sensor
4 can be used, first to transmit a sonic pulse and then to receive the return in
5 an alternating fashion. The elapsed time between an ultrasonic pulse being
6 transmitted and a significant echo being received corresponds to the distance
7 between ultrasonic sensor **89** and the object being sensed. Of course, the
8 distance between the ultrasonic sensor **89** and extruded film tube **81** corres-
9 ponds to the circumference of extruded film tube **81**. In the present situation,
10 ultrasonic sensor **89** emits an interrogating ultrasonic beam **87** substantially
11 normal to extruded film tube **81** and which is deflected from the outer surface
12 of extruded film tube **81** and sensed by ultrasonic sensor **89**.

13 The Massa Products Corporation ultrasonic measurement and control
14 system includes system electronics which utilize the duration of time between
15 transmission and reception to produce a useable electrical output such as a
16 voltage or current. In the preferred embodiment, ultrasonic sensor **89** is
17 coupled to sizing cage **23** at adjustable coupling **83**. In the preferred embodi-
18 ment, ultrasonic sensor **89** is positioned within seven inches of extruded film
19 tube **81** to minimize the impact of ambient noise on a control system. Ultra-
20 sonic sensor **89** is positioned so that interrogating ultrasonic beam **87** travels
21 through a path which is substantially normal to the outer surface of extruded
22 film tube **81**, to maximize the return signal to ultrasonic sensor **89**.

23 **Figure 4** is a view of ultrasonic sensor **89** of **Figure 3** coupled to sizing
24 cage **23** of the blown film tower **13**, in two positions, one position being
25 shown in phantom. In the first position, ultrasonic sensor **89** is shown
26 adjacent extruded film tube **81** of a selected circumference. When extruded
27 film tube **81** is downsized to a tube having a smaller circumference, ultrasonic
28 sensor **89** will move inward and outward relative to the central axis of the
29 adjustable sizing cage, along with the adjustable sizing cage **23**. The second
30 position is shown in phantom with ultrasonic sensor **89** shown adjacent
31 extruded film tube **81** of a smaller circumference. For purposes of reference,

1 internal air diffuser **51** and exhaust stack **53** are shown in **Figure 4**. The
2 sizing cage is also movable upward and downward, so ultrasonic sensor **89**
3 is also movable upward and downward relative to the frostline of the extruded
4 film tube **81**.

5 **Figure 5** is a schematic and block diagram view of the preferred con-
6 trol system of the present invention. The preferred acoustic transducer **79** of
7 the present invention includes ultrasonic sensor **89** and temperature sensor
8 **91** which cooperate to produce a current position signal which is independent
9 of the ambient temperature. Ultrasonic sensor **89** is electrically coupled to
10 ultrasonic electronics module **95**, and temperature sensor **91** is electrically
11 coupled to temperature electronics module **97**. Together, ultrasonic elec-
12 tronics module **95** and temperature electronics module **97** comprise trans-
13 ducer electronics **93**. Four signals are produced by acoustic transducer **79**,
14 including one analog signal, and three digital signals.

15 As shown in **Figure 5**, four conductors couple transducer electronics
16 to supervisory control unit **75**. Specifically, conductor **99** routes a 0 to 10
17 volts DC analog input to supervisory control unit **75**. Conductors **101**, **103**,
18 and **105** provide digital signals to supervisory control unit **75** which
19 correspond to a target present signal, maximum override, and minimum
20 override. These signals will be described below in greater detail.

21 Supervisory control unit **75** is electrically coupled to setpoint display
22 **109** through analog display output **107**. An analog signal between 0 and 10
23 volts DC is provided to setpoint display **109** which displays the selected
24 distance between ultrasonic sensor **89** and extruded film tube **81**. A distance
25 is selected by the operator through distance selector **111**. Target indicator
26 **113**, preferably a light, is provided to indicate that the target (extruded film
27 tube **81**) is in range. Distance selector **111** is electrically coupled to super-
28 visory control unit **75** by distance setting conductor **119**. Target indicator **113**
29 is electrically coupled to supervisory control unit **75** through target present
30 conductor **121**.

Supervisory control unit **75** is also coupled via valve control conductor **123** to proportional valve **125**. In the preferred embodiment, proportional valve **125** corresponds to valve **47** of **Figure 1**, and is a pressure control component manufactured by Proportionair of McCordsville, Indiana, Model No. BB1. Proportional valve **125** translates an analog DC voltage provided by supervisory control unit **75** into a corresponding pressure between .5 and 1.2 bar. Proportional valve **125** acts on rotary valve **129** through cylinder **127**. Pressurized air is provided to proportional valve **125** from pressurized air supply **131** through 20 micron filter **133**.

Figure 6 is a schematic and block diagram view of the preferred control system of **Figure 5**, with special emphasis on the supervisory control unit **75**. Extruded film tube **81** is shown in cross-section with ultrasonic sensor **89** adjacent its outer wall. Ultrasonic sensor **89** emits interrogating pulses which are bounced off of extruded film tube and sensed by ultrasonic sensor **89**. The time delay between transmission and reception of the interrogating pulse is processed by transducer electronics **93** to produce four outputs: CURRENT POSITION signal which is provided to supervisory control unit **75** via analog output conductor **99**, digital TARGET PRESENT signal which is provided over digital output **105**, a minimum override signal (MIO signal) indicative of a collapsing or undersized bubble which is provided over digital output conductor **103**, and maximum override signal (MAO signal) indicative of an overblown extruded film tube **81** which is provided over a digital output conductor **101**.

As shown in **Figure 6**, the position of extruded film tube **81** relative to ultrasonic sensor **89** is analyzed and controlled with reference to a number of distance thresholds and setpoints, which are shown in greater detail in **Figure 7A**. All set points and thresholds represent distances from reference R. The control system of the present invention attempts to maintain extruded film tube **81** at a circumference which places the wall of extruded film tube **81** at a tangent to the line established by reference A. The distance between reference R and set point A may be selected by the user through distance

1 selector **111**. This allows the user to control the distance between ultrasonic
2 sensor **89** and extruded film tube **81**.

3 The operating range of acoustic transducer **79** is configurable by the
4 user with settings made in transducer electronics **93**. In the preferred embodi-
5 ment, using the Massa Products transducer, the range of operation of
6 acoustic transducer **79** is between 3 to 24 inches. Therefore, the user may
7 select a minimum circumference threshold C and a maximum circumference
8 threshold B, below and above which an error signal is generated. Minimum
9 circumference threshold C may be set by the user at a distance d3 from
10 reference R. Maximum circumference threshold B may be selected by the
11 user to be a distance d2 from reference R. In the preferred embodiment,
12 setpoint A is set a distance of 7 inches from reference R. Minimum
13 circumference threshold C is set a distance of 10.8125 inches from reference
14 R. Maximum circumference threshold B is set a distance of 4.1 inches from
15 reference R. Transducer electronics **93** allows the user to set or adjust these
16 distances at will provided they are established within the range of operation
17 of acoustic transducer **79**, which is between 3 and 24 inches.

18 Besides providing an analog indication of the distance between
19 ultrasonic sensors **89** and extruded film tube **81**, transducer electronics **93**
20 also produces three digital signals which provide information pertaining to the
21 position of extruded film tube **81**. If extruded film tube **81** is substantially
22 normal and within the operating range of ultrasonic sensor **89**, a digital "1" is
23 provided at digital output **105**. The signal is representative of a TARGET
24 PRESENT signal. If extruded film tube **81** is not within the operating range
25 of ultrasonic sensor **89** or if a return pulse is not received due to curvature of
26 extruded film tube **81**, TARGET PRESENT signal of digital output **105** is low.
27 As discussed above, digital output **103** is a minimum override signal MIO. If
28 extruded film tube **81** is smaller in circumference than the reference estab-
29 lished by threshold C, minimum override signal MIO of digital output **103** is
30 high. Conversely, if circumference of extruded film tube **81** is greater than

1 the reference established by threshold C, the minimum override signal MIO
2 is low.

3 Digital output **101** is for a maximum override signal MAO. If extruded
4 film tube **81** is greater than the reference established by threshold B, the
5 maximum override signal MAO is high. Conversely, if the circumference of
6 extruded film tube **81** is less than the reference established by threshold B,
7 the output of maximum override signal MAO is low.

8 The minimum override signal MIO will stay high as long as extruded
9 film tube **81** has a circumference less than that established by threshold C.
10 Likewise, the maximum override signal MAO will remain high for as long as
11 the circumference of extruded film tube **81** remains larger than the reference
12 established by threshold B.

13 Threshold D and threshold E are also depicted in **Figure 7A**.
14 Threshold D is established at a distance d4 from reference R. Threshold E
15 is established at a distance d5 from reference R. Thresholds D and E are
16 established by supervisory control unit **75**, not by acoustic transducer **79**.
17 Threshold D represents a minimum circumference threshold for extruded film
18 tube **81** which differs from that established by transducer electronics **93**.
19 Likewise, threshold E corresponds to a maximum circumference threshold
20 which differs from that established by acoustic transducer **79**. Thresholds D
21 and E are established in the software of supervisory control unit **75**, and
22 provide a redundancy of control, and also minimize the possibility of user
23 error, since these threshold are established in software, and cannot be easily
24 changed or accidentally changed. The coordination of all of these thresholds
25 will be discussed in greater detail below. In the preferred embodiment,
26 threshold C is established at 10.8125 inches from reference R. Threshold E
27 is established at 3.6 inches from reference R.

28 **Figure 7B** is a side view of the ultrasonic sensor **89** coupled to sizing
29 cage **23** of the blown film tower **13**, with permissible extruded film tube **81**
30 operating ranges indicated thereon. Setpoint A is the desired distance
31 between ultrasonic sensor **89** and extruded film tube **81**. Thresholds D and

1 C are established at selected distances inward from ultrasonic sensor **89**, and
2 represent minimum circumference thresholds for extruded film tube **81**.
3 Thresholds B and E are established at selected distances from setpoint A,
4 and establish separate maximum circumference thresholds for extruded film
5 tube **81**. As shown in **Figure 7B**, extruded film tube **81** is not at setpoint A.
6 Therefore, additional air must be supplied to the interior of extruded film tube
7 **81** to expand the extruded film tube **81** to the desired circumference estab-
8 lished by setpoint A.

9 If extruded film tube **81** were to collapse, two separate alarm conditions
10 would be registered. One alarm condition will be established when extruded
11 film tube **81** falls below threshold C. A second and separate alarm condition
12 will be established when extruded film tube **81** falls below threshold D.
13 Extruded film tube **81** may also become overblown. In an overblown condi-
14 tion, two separate alarm conditions are possible. When extruded film tube **81**
15 expands beyond threshold B, an alarm condition is registered. When
16 extruded film tube **81** expands further to extend beyond threshold E, a
17 separate alarm condition is registered.

18 As discussed above, thresholds C and B are subject to user
19 adjustment through settings in transducer electronics **93**. In contrast,
20 thresholds D and E are set in computer code of supervisory control unit **75**,
21 and are not easily adjusted. This redundancy in control guards against
22 accidental or intentional missetting of the threshold conditions at transducer
23 electronics **93**. The system also guards against the possibility of equipment
24 failure in transducer **79**, or gradual drift in the threshold settings due to
25 deterioration, or overheating of the electronic components contained in
26 transducer electronics **93**.

27 Returning now to **Figure 6**, operator control panel **137** and supervisory
28 control unit **75** will be described in greater detail. Operator control panel **137**
29 includes setpoint display **109**, which serves to display the distance d1
30 between reference R and setpoint A. Setpoint display **109** includes a 7
31 segment display. Distance selector **111** is used to adjust setpoint A. Holding

1 the switch to the "+" position increases the circumference of extruded film
2 tube **81** by decreasing distance d1 between setpoint A and reference R.
3 Holding the switch to the "-" position decreases the diameter of extruded film
4 tube **81** by increasing the distance between reference R and setpoint A.

5 Target indicator **113** is a target light which displays information
6 pertaining to whether extruded film tube **81** is within range of ultrasonic
7 transducer **89**, whether an echo is received at ultrasonic transducer **89**, and
8 whether any alarm condition has occurred. Blower switch **139** is also pro-
9 vided in operator control panel **137** to allow the operator to selectively
10 disconnect the blower from the control unit. As shown in **Figure 6**, all these
11 components of operator control panel **137** are electrically coupled to super-
12 visory control unit **75**.

13 Supervisory control unit **75** responds to the information provided by
14 acoustic transducer **79**, and operator control panel **137** to actuate proportional
15 valve **125**. Proportional valve **125** in turn acts upon pneumatic cylinder **127**
16 to rotate rotary valve **129** to control the air flow to the interior of extruded film
17 tube **81**.

18 With the exception of analog to digital converter **141**, digital to analog
19 converter **143**, and digital to analog converter **145** (which are hardware
20 items), supervisory control unit **75** is a graphic representation of computer
21 software resident in memory of supervisory control unit **75**. In the preferred
22 embodiment, supervisory control unit **75** comprises an industrial controller,
23 preferably a Texas Instrument brand industrial controller Model No. PM550.
24 Therefore, supervisory control unit **75** is essentially a relatively low-powered
25 computer which is dedicated to a particular piece of machinery for monitoring
26 and controlling. In the preferred embodiment, supervisory control unit **75**
27 serves to monitor many other operations of blown film extrusion line **11**. The
28 gauging and control of the circumference of extruded film tube **81** through
29 computer software is one additional function which is "piggybacked" onto the
30 industrial controller. Alternately, it is possible to provide an industrial
31 controller or microcomputer which is dedicated to the monitoring and control

1 of the extruded film tube **81**. Of course, dedicating a microprocessor to this
2 task is a rather expensive alternative.

3 For purposes of clarity and simplification of description, the operation
4 of the computer program in supervisory control unit **75** have been segregated
5 into operational blocks, and presented as an amalgamation of digital hard-
6 ware blocks. In the preferred embodiment, these software subcomponents
7 include: software filter **149**, health state logic **151**, automatic sizing and
8 recovery logic **153**, loop mode control logic **155**, volume setpoint control logic
9 **157**, and output clamp **159**. These software modules interface with one
10 another, and to PI loop program **147** of supervisory control unit **75**. PI loop
11 program is a software routine provided in the Texas Instruments' PM550
12 system. The proportional controller regulates a process by manipulating a
13 control element through the feedback of a controlled output. The equation for
14 the output of a PI controller is:

$$m = K \cdot e + K/T \int e \, dt + ms$$

16 In this equation:

17 m = controller output

18 K = controller gain

19 e = error

20 T = reset time

21 dt = differential time

22 ms = constant

23 $\int e \, dt$ = integration of all previous errors
24
25

26 When an error exists, it is summed (integrated) with all the
27 previous errors, thereby increasing or decreasing the output of the PI con-
28 troller (depending upon whether the error is positive or negative). Thus as
29 the error term accumulates in the integral term, the output changes so as to
30 eliminate the error.

31 CURRENT POSITION signal is provided by acoustic transducer **79** via
32 analog output **99** to analog to digital converter **141**, where the analog CUR-
33 RENT POSITION signal is digitized. The digitized CURRENT POSITION sig-
34 nal is routed through software filter **149**, and then to PI loop program **147**.

1 If the circumference of extruded film tube **81** needs to be adjusted, PI loop
2 program **147** acts through output clamp **159** upon proportional valve **125** to
3 adjust the quantity of air provided to the interior of extruded film tube **81**.

4 **Figure 8A** is a flowchart of the preferred filtering process applied to
5 CURRENT POSITION signal generated by the acoustic transducer. The digi-
6 tized CURRENT POSITION signal is provided from analog to digital converter
7 **141** to software filter **149**. The program reads the CURRENT POSITION sig-
8 nal in step **161**. Then, the software filter **149** sets SAMPLE (N) to the
9 position signal.

10 In step **165**, the absolute value of the difference between CURRENT
11 POSITION (SAMPLE (N)) and the previous sample (SAMPLE (N - 1)) is com-
12 pared to a first threshold. If the absolute value of the difference between the
13 current sample and the previous sample is less than first threshold T1, the
14 value of SAMPLE (N) is set to CFS, the current filtered sample, in step **167**.
15 If the absolute value of the difference between the current sample and the
16 previous sample exceeds first threshold T1, in step **169**, the CURRENT
17 POSITION signal is disregarded, and the previous position signal SAMPLE
18 (N - 1) is substituted in its place.

19 Then, in step **171**, the suggested change SC is calculated, by
20 determining the difference between the current filtered sample CFS and the
21 best position estimate BPE. In step **173**, the suggested change SC which
22 was calculated in step **171** is compared to positive T2, which is the maximum
23 limit on the rate of change. If the suggested change is within the maximum
24 limit allowed, in step **177**, allowed change AC is set to the suggested change
25 SC value. If, however, in step **173**, the suggested change exceeds the
26 maximum limit allowed on the rate of change, in step **175**, the allowed
27 change is set to +LT2, a default value for allowed change.

28 In step **179**, the suggested change SC is compared to the negative
29 limit for allowable rates of change, negative T2. If the suggested change SC
30 is greater than the maximum limit on negative change, in step **181**, allowed
31 change AC is set to negative -LT2, a default value for negative change.

1 However, if in step **179** it is determined that suggested change SC is within
2 the maximum limit allowed on negative change, in step **183**, the allowed
3 change AC is added to the current best position estimate BPE, in step **183**.
4 Finally, in step **185**, the newly calculated best position estimate BPE is written
5 to the PI loop program.

6 Software filter **149** is a two stage filter which first screens the
7 CURRENT POSITION signal by comparing the amount of change, either
8 positive or negative, to threshold T1. If the CURRENT POSITION signal, as
9 compared to the preceding position signal exceeds the threshold of T1, the
10 current position signal is discarded, and the previous position signal
11 (SAMPLE (N - 1)) is used instead. At the end of the first stage, in step **171**,
12 a suggested change SC value is derived by subtracting the best position
13 estimate BPE from the current filtered sample CFS.

14 In the second stage of filtering, the suggested change SC value is
15 compared to positive and negative change thresholds (in steps **173** and **179**).
16 If the positive or negative change thresholds are violated, the allowable
17 change is set to a preselected value, either +LT2, or -LT2. Of course, if the
18 suggested change SC is within the limits set by positive T2 and negative T2,
19 then the allowable change AC is set to the suggested change SC.

20 The operation of software filter **149** may also be understood with
21 reference to **Figure 8B**. In the graph of **Figure 8B**, the y-axis represents the
22 signal level, and the x-axis represents time. The signal as sensed by
23 acoustic transducer **79** is designated as input, and shown in the solid line.
24 The operation of the first stage of the software filter **149** is depicted by the
25 current filtered sample CFS, which is shown in the graph by cross-marks. As
26 shown, the current filtered sample CFS operates to ignore large positive or
27 negative changes in the position signal, and will only change when the posi-
28 tion signal seems to have stabilized for a short interval. Therefore, when
29 changes occur in the current filtered sample CFS, they occur in a plateau-like
30 manner.

1 In stage two of the software filter **149**, the current filtered sample CFS
2 is compared to the best position estimate BPE, to derive a suggested change
3 SC value. The suggested SC is then compared to positive and negative
4 thresholds to calculate an allowable change AC which is then added to the
5 best position estimate BPE. Figure 8B shows that the best position estimate
6 BPE signal only gradually changes in response to an upward drift in the
7 POSITION SIGNAL. The software filtering system **149** of the present inven-
8 tion renders the control apparatus relatively unaffected by random noise, but
9 capable of tracking the more "gradual" changes in bubble position.

10 Experimentation has revealed that the software filtering system of the
11 present invention operates best when the position of extruded film tube **81** is
12 sampled between 20 to 30 times per second. At this sampling rate, one is
13 less likely to incorrectly identify noise as a change in circumference of
14 extruded film tube **81**. The preferred sampling rate accounts for the common
15 noise signals encountered in blown film extrusion liner.

16 Optional thresholds have also been derived through experimentation.
17 In the first stage of filtering, threshold T1 is established as roughly one
18 percent of the operating range of acoustic transducer **79**, which in the
19 preferred embodiment is twenty-one meters (24 inches less 3 inches). In the
20 second stage of filter, thresholds +LT2 and -LT2 are established as roughly
21 0.30% of the operating range of acoustic transducer **79**.

22 **Figure 9** is a schematic representation of the automatic sizing and
23 recovery logic ASRL of supervisory control unit **75**. As stated above, this
24 figure is a hardware representation of a software routine. ASRL **153** is
25 provided to accommodate the many momentary false indications of maximum
26 and minimum circumference violations which may be registered due to noise,
27 such as the noise created due to air flow between acoustic transducer **79** and
28 extruded film tube **81**. The input from maximum alarm override MAO is
29 "ored" with high alarm D, from the PI loop program, at "or" operator **191**.
30 High alarm D is the signal generated by the program in supervisory control
31 unit **75** when the circumference of extruded film tube **81** exceeds threshold

1 D of **Figure 7A**. If a maximum override MAO signal exists, or if a high alarm
2 condition D exists, the output of "or" operator **191** goes high, and actuates
3 delay timer **193**.

4 Likewise, minimum override MIO signal is "ored" at "or" operator **195**
5 with low alarm E. If a minimum override signal is present, or if a low alarm
6 condition E exists, the output of "or" operator **195** goes high, and is directed
7 to delay timer **197**. Delay timers **193**, **197** are provided to prevent an alarm
8 condition unless the condition is held for 800 milliseconds continuously.
9 Every time the input of delay timers **193**, **197** goes low, the timer resets and
10 starts from 0. This mechanism eliminates many false alarms.

11 If an alarm condition is held for 800 milliseconds continuously, an
12 OVERBLOWN or UNDERBLOWN signal is generated, and directed to the
13 health state logic **151**. Detected overblown or underblown conditions are
14 "ored" at "or" operator **199** to provide a REQUEST MANUAL MODE signal
15 which is directed to loop mode control logic **155**.

16 **Figure 10** is a schematic representation of the health-state logic **151**
17 of **Figure 6**. The purpose of this logic is to control the target indicator **113** of
18 operator control panel **137**. When in non-error operation, the target indicator
19 **113** is on if the blower is on, and the TARGET PRESENT signal from digital
20 output **105** is high. When an error is sensed in the maximum override MAO
21 or minimum override MIO lines, the target indicator **113** will flash on and off
22 in one half second intervals.

23 In health-state logic HSL **151**, the maximum override signal MAO is
24 inverted at inverter **205**. Likewise, the minimum override signal is inverted at
25 inverter **207**.

26 "And" operator **209** serves to "and" the inverted maximum override
27 signal MAO, with the OVERBLOWN signal, and high alarm signal D. A high
28 output from "and" operator **209** indicates that something is wrong with the
29 calibration of acoustic transducer **79**.

30 Likewise, "and" operator **213** serves to "and" the inverted minimum
31 override signal MIO, with the OVERBLOWN signal, and low alarm signal E.

1 If the output of "and" operator **213** is high, something is wrong with the
2 calibration of acoustic transducer **79**. The outputs from "and" operators **209**,
3 **213** are combined in "or" operator **215** to indicate an error with either the
4 maximum or minimum override detection systems. The output of "or" opera-
5 tor **215** is channeled through oscillator **219**, and inverted at inverter **217**.
6 "And" operator **211** serves to "and" the TARGET PRESENT signal, blower
7 signal, and inverted error signal from "or" operator **215**. The output of "and"
8 operator of **211** is connected to target indicator **113**.

9 If acoustic transducer **79** is properly calibrated, the target is within
10 range and normal to the sonic pulses, and the blower is on, target indicator
11 **113** will be on. If the target is within range and normal to the sonic pulses,
12 the blower is on, but acoustic transducer **79** is out of calibration, target
13 indicator **113** will be on, but will be blinking. The blinking signal indicates that
14 acoustic transducer **79**, and in particular transducer electronics **93**, must be
15 recalibrated.

16 **Figure 11** is a schematic representation of loop mode control logic
17 LMCL of **Figure 6**. The purpose of this software module is coordinate the
18 transition in modes of operation. Specifically, this software module
19 coordinates automatic startup of the blown film extrusion process, as well as
20 changes in mode between an automated "cascade" mode and a manual
21 mode, which is the required mode of the PI controller to enable under and
22 overblown conditions of the extruded film tube **81** circumference. The
23 plurality of input signals are provided to loop mode control logic **155**,
24 including: BLOWER ON, REQUEST MANUAL MODE, PI LOOP IN
25 CASCADE MODE, UNDERBLOWN and OVERBLOWN. Loop mode control
26 logic LMCL **155** provides two output signals: MANUAL MODE, and
27 CASCADE MODE.

28 **Figure 11** includes a plurality of digital logic blocks which are
29 representative of programming operations. "Or" operator **225** "ores" the
30 inverted BLOWER ON SIGNAL to the REQUEST MANUAL MODE SIGNAL.
31 "And" operator **227** "ands" the inverted REQUEST MANUAL MODE SIGNAL

1 with an inverted MANUAL MODE SIGNAL, and the BLOWER ON SIGNAL.
2 "And" operator **229** "ands" the REQUEST MANUAL MODE SIGNAL to the
3 inverted CASCADE MODE SIGNAL. This prevents MANUAL MODE and
4 CASCADE MODE from both being on at the same time. "And" operator **231**
5 "ands" the MANUAL MODE SIGNAL, the inverted UNDERBLOWN SIGNAL,
6 and the OVERBLOWN SIGNAL. "And" operator **233** "ands" the MANUAL
7 MODE SIGNAL with the UNDERBLOWN SIGNAL. This causes the over-
8 blown condition to prevail in the event a malfunction causes both underblown
9 and overblown conditions to be on. Inverters **235, 237, 239, 241, and 243**
10 are provided to invert the inputted output signals of loop mode control logic
11 **155** were needed. Software one-shot **245** is provided for providing a momen-
12 tary response to a condition. Software one-shot **245** includes "and" operator
13 **247**, off-delay **249**, and inverter **251**.

14
15 The software of loop mode control logic **155** operates to ensure
16 that the system is never in MANUAL MODE, and CASCADE MODE at the
17 same time. When manual mode is requested by REQUEST MANUAL
18 MODE, loop mode control logic **155** causes MANUAL MODE to go high.
19 When manual mode is not requested, loop mode control logic **155** operates
20 to cause CASCADE MODE to go high. MANUAL MODE and CASCADE
21 MODE will never be high at the same time. Loop mode control logic **155** also
22 serves to ensure that the system provides a "bumpless transfer" when mode
23 changes occur. The term "cascade mode" is understood in the automation
24 industries as referring to an automatic mode which will read an adjustable
25 setpoint.

26
27 Loop mode control logic **155** will also allow for automatic startup
28 of the blown film extrusion process. At startup, UNDERBLOWN SIGNAL is
29 high, PI LOOP IN CASCADE MODE is low, BLOWER ON SIGNAL is high.
30 These inputs (and inverted inputs) are combined at "and" operators **231, 233**.
31 At startup, "and" operator **233** actuates logic block **253** to move the maximum

1 air flow value address to the PI loop step **261**. At startup, the MANUAL
2 MODE SIGNAL is high. For the PI loop controller of the preferred
3 embodiment, when MANUAL MODE is high, the value contained in PI loop
4 output address is automatically applied to proportional valve **125**. This results
5 in actuation of proportional valve **125** to allow maximum air flow to start the
6 extruded film tube **81**.

7
8 When extruded film tube **81** extends in size beyond the minimum
9 threshold (C and D of **Figure 7A**), the UNDERBLOWN SIGNAL goes low,
10 and the PI LOOP IN CASCADE MODE signal goes high. This causes
11 software one-shot **245** to trigger, causing logic blocks **265**, **267** to push an
12 initial bias value contained in a program address onto the PI loop.
13 Simultaneously, logic blocks **269**, **271** operate to place the selected setpoint
14 value A onto volume-setpoint control logic VSCL **157**. Thereafter,
15 volume-setpoint control logic VSCL **157** alone serves to communicate
16 changes in setpoint value A to PI loop program **147**.

17
18 If an overblown or underblown condition is detected for a
19 sufficiently long period of time, the controller will request a manual mode by
20 causing REQUEST MANUAL MODE SIGNAL to go high. If REQUEST
21 MANUAL MODE goes high, loop mode control logic LMCL **155** supervises
22 the transfer through operation of the logic blocks.

23
24 Loop mode control logic LMCL **155** also serves to detected
25 overblown and underblown conditions. If an overblown or underblown condi-
26 tion is detected by the control system, REQUEST MANUAL MODE goes high,
27 and the appropriate OVERBLOWN or UNDERBLOWN signal goes high. The
28 logic operators of loop mode control logic LMCL **155** operate to override the
29 normal operation of the control system, and cause maximum or minimum air
30 flow by putting the maximum air flow address **261** or minimum air flow
31 address **263** to the PI output address. As stated above, when MANUAL

1 MODE is high, these maximum or minimum air flow address values are
2 outputted directly to proportional valve 125. Thus, when the extruded film
3 tube 81 is overblown, loop mode control logic LMCL 155 operates to
4 immediately cause proportional valve 125 to minimize air flow to extruded film
5 tube 81. Conversely, if an underblown condition is detected, loop mode
6 control logic LMCL 155 causes proportional valve 125 to immediately
7 maximize air flow to extruded film tube 81.

8
9 Figure 12 depicts the operation of volume-setpoint control logic
10 VSCL 157.

11
12 Volume setpoint control logic VSCL 157 operates to increase or
13 decrease setpoint A in response to changes made by the operator at distance
14 selector 111 of operator control panel 137, when the PI loop program 147 is
15 in cascade mode, i.e. when PI LOOP IN CASCADE MODE signal is high.
16 The INCREASE SETPOINT, DECREASE SETPOINT, and PI LOOP IN
17 CASCADE MODE signals are logically combined at "and" operators 283, and
18 287. These "and" operators act on logic blocks 285, 289 to increase or
19 decrease the setpoint contained in remote setpoint address 291. When the
20 setpoint is either increased or decreased, logic block 293 operates to add the
21 offset to the remote setpoint for display, and forwards the information to
22 digital to analog converter 143, for display at setpoint display 109 of operator
23 control panel 137. The revised remote setpoint address is then read by the
24 PI loop program 147.

25
26 Figure 13 is a flowchart drawing of output clamp 159. The
27 purpose of this software routine is to make sure that the PI loop program 147
28 does not over drive the rotary valve 129 past a usable limit. Rotary valve 129
29 operates by moving a vane to selectively occlude stationary openings. If the
30 moving vane is over driven, the rotary valve will begin to open when the PI
31 loop calls for complete closure. In step 301, the output of the PI loop

1 program 147 is read. In step 303, the output of PI loop is compared to a
2 maximum output. If it exceeds the maximum output, the PI output is set to
3 a predetermined maximum output in step 305. If the output of PI loop does
4 not exceed the maximum output, in step 307, the clamped PI output is written
5 to the proportional valve 125 through digital to analog converter 145.
6

7 Figures 14, through 27 will be used to describe an alternative
8 emergency condition control mode of operation which provides enhanced
9 control capabilities, especially when an overblown or underblown condition is
10 detected by the control system, or when the system indicates that the
11 extruded film tube is out of range of the position-sensing transducer. In this
12 alternative emergency condition control mode of operation, the valve of the
13 estimated position is advanced to a preselected valve and a more rapid
14 change in the estimated position signal is allowed than during previously
15 discussed operating conditions, and is particularly useful when an overblown
16 or underblown condition is detected. In the event the control system indicates
17 that the extruded film tube is out of range of the sensing transducer, the
18 improved control system supplies an estimated position which, in most situa-
19 tions, is a realistic estimation of the position of the extruded film tube relative
20 to the sensing transducer, thus preventing false indications of the extruded
21 film tube being out of range of the sensing transducer from adversely affect-
22 ing the estimated position of the extruded film tube, greatly enhancing opera-
23 tion of the control system. In the event an overblown condition is detected,
24 the improved control system supplies an estimated position which corres-
25 ponds to the distance boundary established for detecting an overflow
26 condition. In the event an underblown condition is detected, the improved
27 control system supplies an estimated position which corresponds to the
28 distance boundary established for detecting an underblown condition.
29

30 Figures 14, through 27 are a block diagram, schematic, and
31 flowchart representation of the preferred embodiment of a control system

1 which is equipped with the alternative emergency condition control mode of
2 operation. Figures 25, 26, and 27 provide graphic examples of the operation
3 of this alternative emergency condition control mode of operation.
4

5 Figure 14 is a schematic and block diagram view of the
6 preferred alternative control system 400 of the present invention of Figure 5,
7 with special emphasis on the supervisory control unit 75, and is identical in
8 almost all respects to the supervisory control unit 75 which is depicted in
9 Figure 6; therefore, identical referenced numerals are used to identify the
10 various components of alternative control system 400 of Figure 14 as are
11 used in the control system depicted in Figure 6.
12

13 Extruded film tube 81 is shown in cross-section with ultrasonic
14 sensor 89 adjacent its outer wall. Ultrasonic sensor 89 emits interrogating
15 pulses which are bounced off of extruded film tube and sensed by ultrasonic
16 sensor 89. The time delay between transmission and reception of the
17 interrogating pulse is processed by transducer electronics 93 to produce four
18 outputs: CURRENT POSITION signal which is provided to supervisory
19 control unit 75 via analog output conductor 99, digital TARGET PRESENT
20 signal which is provided over digital output 105, a minimum override signal
21 (MIO signal) indicative of a collapsing or undersized bubble which is provided
22 over digital output conductor 103, and maximum override signal (MAO signal)
23 indicative of an overblown extruded film tube 81 which is provided over a
24 digital output conductor 101.
25

26 As shown in Figure 14, the position of extruded film tube 81
27 relative to ultrasonic sensor 89 is analyzed and controlled with reference to
28 a number of distance thresholds and setpoints, which are shown in greater
29 detail in Figure 15. All set points and thresholds represent distances from
30 reference R. The control system of the present invention attempts to
31 maintain extruded film tube 81 at a circumference which places the wall of

1 extruded film tube 81 at a tangent to the line established by reference A. The
2 distance between reference R and set point A may be selected by the user
3 through distance selector 111. This allows the user to control the distance
4 between ultrasonic sensor 89 and extruded film tube 81.

5
6 The operating range of acoustic transducer 79 is configurable
7 by the user with settings made in transducer electronics 93. In the preferred
8 embodiment, using the Massa Products transducer, the range of operation of
9 acoustic transducer 79 is between 3 to 24 inches. Therefore, the user may
10 select a minimum circumference threshold C and a maximum circumference
11 threshold B, below and above which an error signal is generated. Minimum
12 circumference threshold C may be set by the user at a distance d3 from
13 reference R. Maximum circumference threshold B may be selected by the
14 user to be a distance d2 from reference R. In the preferred embodiment,
15 setpoint A is set a distance of 7 inches from reference R. Minimum
16 circumference threshold C is set a distance of 10.8125 inches from reference
17 R. Maximum circumference threshold B is set a distance of 4.1 inches from
18 reference R. Transducer electronics 93 allows the user to set or adjust these
19 distances at will provided they are established within the range of operation
20 of acoustic transducer 79, which is between 3 and 24 inches.

21
22 Besides providing an analog indication of the distance between
23 ultrasonic sensors 89 and extruded film tube 81, transducer electronics 93
24 also produces three digital signals which provide information pertaining to the
25 position of extruded film tube 81. If extruded film tube 81 is substantially
26 normal and within the operating range of ultrasonic sensor 89, a digital "1" is
27 provided at digital output 105. The signal is representative of a TARGET
28 PRESENT signal. If extruded film tube 81 is not within the operating range
29 of ultrasonic sensor 89 or if a return pulse is not received due to curvature of
30 extruded film tube 81, TARGET PRESENT signal of digital output 105 is low.
31 As discussed above, digital output 103 is a minimum override signal MIO. If

1 extruded film tube 81 is smaller in circumference than the reference
2 established by threshold C, minimum override signal MIO of digital output 103
3 is high. Conversely, if circumference of extruded film tube 81 is greater than
4 the reference established by threshold C, the minimum override signal MIO
5 is low.

6
7 Digital output 101 is for a maximum override signal MAO. If
8 extruded film tube 81 is greater than the reference established by threshold
9 B, the maximum override signal MAO is high. Conversely, if the
10 circumference of extruded film tube 81 is less than the reference established
11 by threshold B, the output of maximum override signal MAO is low.

12
13 The minimum override signal MIO will stay high as long as
14 extruded film tube 81 has a circumference less than that established by
15 threshold C. Likewise, the maximum override signal MAO will remain high
16 for as long as the circumference of extruded film tube 81 remains larger than
17 the reference established by threshold B.

18
19 Threshold D and threshold E are also depicted in Figure 15.
20 Threshold D is established at a distance d_4 from reference R. Threshold E
21 is established at a distance d_5 from reference R. Thresholds D and E are
22 established by supervisory control unit 75, not by acoustic transducer 79.
23 Threshold D represents a minimum circumference threshold for extruded film
24 tube 81 which differs from that established by transducer electronics 93.
25 Likewise, threshold E corresponds to a maximum circumference threshold
26 which differs from that established by acoustic transducer 79. Thresholds D
27 and E are established in the software of supervisory control unit 75, and
28 provide a redundancy of control, and also minimize the possibility of user
29 error, since these threshold are established in software, and cannot be easily
30 changed or accidentally changed. The coordination of all of these thresholds
31 will be discussed in greater detail below. In the preferred embodiment,

1 threshold C is established at 10.8125 inches from reference R. Threshold E
2 is established at 3.6 inches from reference R.
3

4 Figure 16 is a side view of the ultrasonic sensor 89 coupled to
5 sizing cage 23 of the blown film tower 13, with permissible extruded film tube
6 81 operating ranges indicated thereon. Setpoint A is the desired distance
7 between ultrasonic sensor 89 and extruded film tube 81. Thresholds D and
8 C are established at selected distances inward from ultrasonic sensor 89, and
9 represent minimum circumference thresholds for extruded film tube 81.
10 Thresholds B and E are established at selected distances from setpoint A,
11 and establish separate maximum circumference thresholds for extruded film
12 tube 81. As shown in Figure 16, extruded film tube 81 is not at setpoint A.
13 Therefore, additional air must be supplied to the interior of extruded film tube
14 81 to expand the extruded film tube 81 to the desired circumference
15 established by setpoint A.
16

17 If extruded film tube 81 were to collapse, two separate alarm
18 conditions would be registered. One alarm condition will be established when
19 extruded film tube 81 falls below threshold C. A second and separate alarm
20 condition will be established when extruded film tube 81 falls below threshold
21 D. Extruded film tube 81 may also become overblown. In an overblown
22 condition, two separate alarm conditions are possible. When extruded film
23 tube 81 expands beyond threshold B, an alarm condition is registered. When
24 extruded film tube 81 expands further to extend beyond threshold E, a
25 separate alarm condition is registered.
26

27 As discussed above, thresholds C and B are subject to user
28 adjustment through settings in transducer electronics 93. In contrast,
29 thresholds D and E are set in computer code of supervisory control unit 75,
30 and are not easily adjusted. This redundancy in control guards against
31 accidental or intentional missetting of the threshold conditions at transducer

1 electronics 93. The system also guards against the possibility of equipment
2 failure in transducer 79, or gradual drift in the threshold settings due to
3 deterioration, or overheating of the electronic components contained in
4 transducer electronics 93.

5
6 Returning now to Figure 14, operator control panel 137 and
7 supervisory control unit 75 will be described in greater detail. Operator
8 control panel 137 includes setpoint display 109, which serves to display the
9 distance d1 between reference R and setpoint A. Setpoint display 109
10 includes a 7 segment display. Distance selector 111 is used to adjust
11 setpoint A. Holding the switch to the "+" position increases the circumference
12 of extruded film tube 81 by decreasing distance d1 between setpoint A and
13 reference R. Holding the switch to the "-" position decreases the diameter of
14 extruded film tube 81 by increasing the distance between reference R and
15 setpoint A.

16
17 Target indicator 113 is a target light which displays information
18 pertaining to whether extruded film tube 81 is within range of ultrasonic
19 transducer 89, whether an echo is received at ultrasonic transducer 89, and
20 whether any error condition has occurred. Blower switch 139 is also provided
21 in operator control panel 137 to allow the operator to selectively disconnect
22 the blower from the control unit. As shown in Figure 14, all these
23 components of operator control panel 137 are electrically coupled to
24 supervisory control unit 75.

25
26 Supervisory control unit 75 responds to the information provided
27 by acoustic transducer 79, and operator control panel 137 to actuate
28 proportional valve 125. Proportional valve 125 in turn acts upon pneumatic
29 cylinder 127 to rotate rotary valve 129 to control the air flow to the interior of
30 extruded film tube 81.

1 With the exception of analog to digital converter 141, digital to
2 analog converter 143, and digital to analog converter 145 (which are
3 hardware items), supervisory control unit 75 is a graphic representation of
4 computer software resident in memory of supervisory control unit 75. In one
5 embodiment, supervisory control unit 75 comprises an industrial controller,
6 preferably a Texas Instrument brand industrial controller Model No. PM550.
7 Therefore, supervisory control unit 75 is essentially a relatively low-powered
8 computer which is dedicated to a particular piece of machinery for monitoring
9 and controlling. In the preferred embodiment, supervisory control unit 75
10 serves to monitor many other operations of blown film extrusion line 11. The
11 gauging and control of the circumference of extruded film tube 81 through
12 computer software is one additional function which is "piggybacked" onto the
13 industrial controller. Alternately, it is possible to provide an industrial
14 controller or microcomputer which is dedicated to the monitoring and control
15 of the extruded film tube 81. Of course, dedicating a microprocessor to this
16 task is a rather expensive alternative.

17
18 For purposes of clarity and simplification of description, the
19 operation of the computer program in supervisory control unit 75 have been
20 segregated into operational blocks, and presented as an amalgamation of
21 digital hardware blocks. In the preferred embodiment, these software
22 subcomponents include: software filter 149, emergency condition control
23 mode logic 150, health state logic 151, automatic sizing and recovery logic
24 153, loop mode control logic 155, volume setpoint control logic 157, and
25 output clamp 159. These software modules interface with one another, and
26 to PI loop program 147 of supervisory control unit 75. PI loop program is a
27 software routine provided in the Texas Instruments' PM550 system. The
28 proportional controller regulates a process by manipulating a control element
29 through the feedback of a controlled output. The equation for the output of
30 a PI controller is:

$$m = K * e + K/T \int e dt + ms$$

1 In this equation:

2 m = controller output

3 K = controller gain

4 e = error

5 T = reset time

6 dt = differential time

7 ms = constant

8 $\int e dt$ = integration of all previous errors

9
10
11 When an error exists, it is summed (integrated) with all the
12 previous errors, thereby increasing or decreasing the output of the PI con-
13 troller (depending upon whether the error is positive or negative). Thus as
14 the error term accumulates in the integral term, the output changes so as to
15 eliminate the error.

16 CURRENT POSITION signal is provided by acoustic transducer
17 79 via analog output 99 to analog to digital converter 141, where the analog
18 CURRENT POSITION signal is digitized. The digitized CURRENT POSITION
19 signal is routed through software filter 149, and then to PI loop program 147.
20 If the circumference of extruded film tube 81 needs to be adjusted, PI loop
21 program 147 acts through output clamp 159 upon proportional valve 125 to
22 adjust the quantity of air provided to the interior of extruded film tube 81.

23 Figure 17 is a schematic representation of the automatic sizing
24 and recovery logic ASRL of supervisory control unit 75. As stated above, this
25 figure is a hardware representation of a software routine. ASRL 153 is
26 provided to accommodate the many momentary false indications of maximum
27 and minimum circumference violations which may be registered due to noise,
28 such as the noise created due to air flow between acoustic transducer 79 and
29 extruded film tube 81. The input from maximum alarm override MAO is
30 "ored" with high alarm D, from the PI loop program, at "or" operator 191.
31 High alarm D is the signal generated by the program in supervisory control
32 unit 75 when the circumference of extruded film tube 81 exceeds threshold
33 D of Figure 15. If a maximum override MAO signal exists, or if a high alarm

1 condition D exists, the output of "or" operator 191 goes high, and actuates
2 delay timer 193.

3
4 Likewise, minimum override MIO signal is "ored" at "or" operator
5 195 with low alarm E. If a minimum override signal is present, or if a low
6 alarm condition E exists, the output of "or" operator 195 goes high, and is
7 directed to delay timer 197. Delay timers 193, 197 are provided to prevent
8 an alarm condition unless the condition is held for 800 milliseconds
9 continuously. Every time the input of delay timers 193, 197 goes low, the
10 timer resets and starts from 0. This mechanism eliminates many false
11 alarms.

12
13 If an alarm condition is held for 800 milliseconds continuously,
14 an OVERBLOWN or UNDERBLOWN signal is generated, and directed to the
15 health state logic 151. Detected overblown or underblown conditions are
16 "ored" at "or" operator 199 to provide a REQUEST MANUAL MODE signal
17 which is directed to loop mode control logic 155.

18
19 Figure 18 is a schematic representation of the health-state logic
20 151 of Figure 14. The purpose of this logic is to control the target indicator
21 113 of operator control panel 137. When in non-error operation, the target
22 indicator 113 is on if the blower is on, and the TARGET PRESENT signal
23 from digital output 105 is high. When an error is sensed in the maximum
24 override MAO or minimum override MIO lines, the target indicator 113 will
25 flash on and off in one half second intervals.

26
27 In health-state logic HSL 151, the maximum override signal MAO
28 is inverted at inverter 205. Likewise, the minimum override signal is inverted
29 at inverter 207.

1 "And" operator 209 serves to "and" the inverted maximum
2 override signal MAO, with the OVERBLOWN signal, and high alarm signal D.
3 A high output from "and" operator 209 indicates that something is wrong with
4 the calibration of acoustic transducer 79.

5
6 Likewise, "and" operator 213 serves to "and" the inverted
7 minimum override signal MIO, with the OVERBLOWN signal, and low alarm
8 signal E. If the output of "and" operator 213 is high, something is wrong with
9 the calibration of acoustic transducer 79. The outputs from "and" operators
10 209, 213 are combined in "or" operator 215 to indicate an error with either the
11 maximum or minimum override detection systems. The output of "or"
12 operator 215 is channeled through oscillator 219, and inverted at inverter 217.
13 "And" operator 211 serves to "and" the TARGET PRESENT signal, blower
14 signal, and inverted error signal from "or" operator 215. The output of "and"
15 operator of 211 is connected to target indicator 113.

16
17 If acoustic transducer 79 is properly calibrated, the target is
18 within range and normal to the sonic pulses, and the blower is on, target
19 indicator 113 will be on. If the target is within range and normal to the sonic
20 pulses, the blower is on, but acoustic transducer 79 is out of calibration,
21 target indicator 113 will be on, but will be blinking. The blinking signal
22 indicates that acoustic transducer 79, and in particular transducer electronics
23 93, must be recalibrated.

24
25 Figure 19 is a schematic representation of loop mode control
26 logic LMCL of Figure 14. The purpose of this software module is coordinate
27 the transition in modes of operation. Specifically, this software module
28 coordinates automatic startup of the blown film extrusion process, as well as
29 changes in mode between an automated "cascade" mode and a manual
30 mode, which is the required mode of the PI controller to enable under and
31 overblown conditions of the extruded film tube 81 circumference. The

1 plurality of input signals are provided to loop mode control logic 155,
2 including: BLOWER ON, REQUEST MANUAL MODE, PI LOOP IN
3 CASCADE MODE, UNDERBLOWN and OVERBLOWN. Loop mode control
4 logic LMCL 155 provides two output signals: MANUAL MODE, and
5 CASCADE MODE.

6
7 Figure 19 includes a plurality of digital logic blocks which are
8 representative of programming operations. "Or" operator 225 "ores" the
9 inverted BLOWER ON SIGNAL to the REQUEST MANUAL MODE SIGNAL.
10 "And" operator 227 "ands" the inverted REQUEST MANUAL MODE SIGNAL
11 with an inverted MANUAL MODE SIGNAL, and the BLOWER ON SIGNAL.
12 "And" operator 229 "ands" the REQUEST MANUAL MODE SIGNAL to the
13 inverted CASCADE MODE SIGNAL. This prevents MANUAL MODE and
14 CASCADE MODE from both being on at the same time. "And" operator 231
15 "ands" the MANUAL MODE SIGNAL, the inverted UNDERBLOWN SIGNAL,
16 and the OVERBLOWN SIGNAL. "And" operator 233 "ands" the MANUAL
17 MODE SIGNAL with the UNDERBLOWN SIGNAL. This causes the
18 overblown condition to prevail in the event a malfunction causes both
19 underblown and overblown conditions to be on. Inverters 235, 237, 239, 241,
20 and 243 are provided to invert the inputted output signals of loop mode
21 control logic 155 were needed. Software one-shot 245 is provided for
22 providing a momentary response to a condition. Software one-shot 245
23 includes "and" operator 247, off-delay 249, and inverter 251.

24
25 The software of loop mode control logic 155 operates to ensure
26 that the system is never in MANUAL MODE, and CASCADE MODE at the
27 same time. When manual mode is requested by REQUEST MANUAL
28 MODE, loop mode control logic 155 causes MANUAL MODE to go high.
29 When manual mode is not requested, loop mode control logic 155 operates
30 to cause CASCADE MODE to go high. MANUAL MODE and CASCADE
31 MODE will never be high at the same time. Loop mode control logic 155 also

1 serves to ensure that the system provides a "bumpless transfer" when mode
2 changes occur. The term "cascade mode" is understood in the automation
3 industries as referring to an automatic mode which will read an adjustable
4 setpoint.

5
6 Loop mode control logic 155 will also allow for automatic startup
7 of the blown film extrusion process. At startup, UNDERBLOWN SIGNAL is
8 high, PI LOOP IN CASCADE MODE is low, BLOWER ON SIGNAL is high.
9 These inputs (and inverted inputs) are combined at "and" operators 231, 233.
10 At startup, "and" operator 233 actuates logic block 253 to move the maximum
11 air flow value address to the PI loop step 261. At startup, the MANUAL
12 MODE SIGNAL is high. For the PI loop controller of the preferred
13 embodiment, when MANUAL MODE is high, the value contained in PI loop
14 output address is automatically applied to proportional valve 125. This results
15 in actuation of proportional valve 125 to allow maximum air flow to start the
16 extruded film tube 81.

17
18 When extruded film tube 81 extends in size beyond the minimum
19 threshold (C and D of Figure 15), the UNDERBLOWN SIGNAL goes low,
20 and the PI LOOP IN CASCADE MODE signal goes high. This causes
21 software one-shot 245 to trigger, causing logic blocks 265, 267 to push an
22 initial bias value contained in a program address onto the PI loop.
23 Simultaneously, logic blocks 269, 271 operate to place the selected setpoint
24 value A onto volume-setpoint control logic VSCL 157. Thereafter,
25 volume-setpoint control logic VSCL 157 alone serves to communicate
26 changes in setpoint value A to PI loop program 147.

27
28 If an overblown or underblown condition is detected for a
29 sufficiently long period of time, the controller will request a manual mode by
30 causing REQUEST MANUAL MODE SIGNAL to go high. If REQUEST

1 MANUAL MODE goes high, loop mode control logic LMCL 155 supervises
2 the transfer through operation of the logic blocks.

3
4 Loop mode control logic LMCL 155 also serves to detected
5 overblown and underblown conditions. If an overblown or underblown
6 condition is detected by the control system, REQUEST MANUAL MODE goes
7 high, and the appropriate OVERBLOWN or UNDERBLOWN signal goes high.
8 The logic operators of loop mode control logic LMCL 155 operate to override
9 the normal operation of the control system, and cause maximum or minimum
10 air flow by putting the maximum air flow address 261 or minimum air flow
11 address 263 to the PI output address. As stated above, when MANUAL
12 MODE is high, these maximum or minimum air flow address values are
13 outputted directly to proportional valve 125. Thus, when the extruded film
14 tube 81 is overblown, loop mode control logic LMCL 155 operates to
15 immediately cause proportional valve 125 to minimize air flow to extruded film
16 tube 81. Conversely, if an underblown condition is detected, loop mode
17 control logic LMCL 155 causes proportional valve 125 to immediately
18 maximize air flow to extruded film tube 81.

19
20 Figure 20 depicts the operation of volume-setpoint control logic
21 VSCL 157.

22
23 Volume setpoint control logic VSCL 157 operates to increase or
24 decrease setpoint A in response to changes made by the operator at distance
25 selector 111 of operator control panel 137, when the PI loop program 147 is
26 in cascade mode, i.e. when PI LOOP IN CASCADE MODE signal is high.
27 The INCREASE SETPOINT, DECREASE SETPOINT, and PI LOOP IN
28 CASCADE MODE signals are logically combined at "and" operators 283, and
29 287. These "and" operators act on logic blocks 285, 289 to increase or
30 decrease the setpoint contained in remote setpoint address 291. When the
31 setpoint is either increased or decreased, logic block 293 operates to add the

1 offset to the remote setpoint for display, and forwards the information to
2 digital to analog converter 143, for display at setpoint display 109 of operator
3 control panel 137. The revised remote setpoint address is then read by the
4 PI loop program 147.

5
6 Figure 21 is a flowchart drawing of output clamp 159. The
7 purpose of this software routine is to make sure that the PI loop program 147
8 does not over drive the rotary valve 129 past a usable limit. Rotary valve 129
9 operates by moving a vane to selectively occlude stationary openings. If the
10 moving vane is over driven, the rotary valve will begin to open when the PI
11 loop calls for complete closure. In step 301, the output of the PI loop
12 program 147 is read. In step 303, the output of PI loop is compared to a
13 maximum output. If it exceeds the maximum output, the PI output is set to
14 a predetermined maximum output in step 305. If the output of PI loop does
15 not exceed the maximum output, in step 307, the clamped PI output is written
16 to the proportional valve 125 through digital to analog converter 145.

17
18 As shown in Figure 14, emergency condition control mode logic
19 150 is provided in supervisory control unit 75, and is shown in detail in Figure
20 22. As shown in Figure 22, emergency condition control mode logic 150
21 receives three input signals: the OVER BLOWN signal; the UNDERBLOWN
22 signal; and the TARGET filter signal. The emergency condition control mode
23 logic 150 provides as an output two variables to software filter 149, including:
24 "SPEED HOLD"; and "ALIGN HOLD". The OVERBLOWN signal is directed
25 to anticipation state "or" gate 403 and to inverter 405. The UNDERBLOWN
26 signal is directed to anticipation state "or" gate 403 and to inverter 407. The
27 TARGET signal is directed through inverter 401 to anticipation state "or" gate
28 403, and to "and" gate 409. The output of anticipation "or" gate 403 is the
29 "or" combination of OVERBLOWN signal, and the inverted TARGET signal.
30 Anticipation state "or" gate 403 and "and" gate 419 cooperate to provide a
31 locking logic loop. The output of "or" gate 403 is provided as an input to

1 "and" gate 419. The other input to "and" gate 419 is the output of inverter
2 417. The output of inverter 417 can be considered as a "unlocking" signal.
3 If the OVERBLOWN signal or UNDERBLOWN signal is high, or the inverted
4 TARGET signal is high, the output of anticipation state "or" gate 403 will go
5 high, and will be fed as an input into "and" gate 419, as stated above. The
6 output of anticipation state "or" gate 403 is also provided as an input to "and"
7 gates 413, 411, and 409. The other input to "and" gate 413 is the inverted
8 OVERBLOWN signal. The other input to "and" gate 411 is the inverted
9 UNDERBLOWN signal. The other input to "and" gate 409 is the TARGET
10 signal. The outputs of "and" gates 409, 411, and 413 are provided to "or"
11 gate 415. The output of "or" gate 415 is provided to inverter 417.
12

13 In operation, the detection of an overblown or underblown
14 condition, or an indication that the extruded film tube is out of range of the
15 sensor will cause the output of anticipation state "or" gate 403 to go high.
16 This high output will be fed back through "and" gate 419 as an input to
17 anticipation state "or" gate 403. Of course, the output of "and" gate 419 will
18 be high for so long as neither input to "and" gate 419 is low. Of course, one
19 input to "and" gate 419 is high because a change in the state of the OVER
20 BLOWN signal, the UNDER BLOWN signal, and the TARGET signal has
21 been detected. The other input to "and" gate 419 is controlled by the output
22 of inverter 417, which is controlled by the output of next-state "or" gate 415.
23 As stated above, the output of next-state "or" gate 415 is controlled by the
24 output of "and" gates 409, 411, 413. In this configuration, anticipation state
25 "or" gate 403 and "and" gate 419 are locked in a logic loop until a change is
26 detected in a binary state of one of the following signals: the OVERBLOWN
27 signal, the UNDERBLOWN signal, and the TARGET signal. A change in
28 state of one of these signals causes next-state "or" gate 415 to go high,
29 which causes the output of inverter 417 to go low, which causes the output
30 of "and" gate 419 to go low.
31

1 The output of next-state "or" gate 415 is also provided to timer
2 starter 421, the reset pin for timer starter 421, and the input of block 423.
3 When a high signal is provided to the input of timer starter 421, a three
4 second software clock is initiated. At the beginning of the three second
5 period, the output of timer starter 421 goes from a normally high condition to
6 a temporary low condition; at the end of the three second software timer, the
7 output of timer starter 421 returns to its normally high condition. If any
8 additional changes in the state of the OVERBLOWN signal, the
9 UNDERBLOWN signal, and the TARGET signal are detected, the software
10 timer is reset to zero, and begins running again. The particular change in the
11 input signal of the OVERBLOWN signal, the UNDERBLOWN signal, and the
12 TARGET signal, also causes the transmission of a high output from "and"
13 gates 409, 411, and 413 to blocks 429, 427, and 425 respectively.
14

15 In operation, when the input to block 423 goes high, the numeric
16 value associated with the variable identified as "quick filter align" will be
17 pushed to a memory variable identified as "speed hold". "Quick filter align"
18 is a filter variable which is used by software filter 149 (of Figure 23, which will
19 be discussed below), which determines the maximum allowable rate of
20 change in determining the estimated position. "Speed hold" is a holding
21 variable which holds the numeric value for the maximum allowable rate of
22 change in determining the estimated position of the blown film tube. "Speed
23 hold" can hold either a value identified as "quick filter align" or a value
24 identified as "normal filter align". "Normal filter align" is a variable that
25 contains a numeric value which determines the normal maximum amount of
26 change allowed in determining the estimated position of the blown film tube
27 relative to the transducer. Blocks 423 and 431 are both coupled to block 433
28 which is an operational block representative of a "push" operation.
29 Essentially, block 433 represents the activity of continuously and
30 asynchronously pushing the value held in the variable "speed hold" to "LT2"
31 in software filter 149 via data bus 402. The value for "normal filter align" is

1 the same as that discussed herebelow in connection with Figure 8a, and
2 comprises thirteen counts, wherein counts are normalized units established
3 in terms of voltage. The preferred value for "quick filter align" is forty-eight
4 counts. Therefore, when the software filter 149 is provided with the quick
5 filter align value, the control system is able to change at a rate of
6 approximately 3.7 times as fast as that during a "normal filter align" mode of
7 operation.

8
9 Also, when a "locked" condition is obtained by anticipation state
10 "or" gate 403 and "and" gate 419, any additional change in state of the values
11 of any of the OVERBLOWN signal, the UNDERBLOWN signal, and the
12 TARGET signal will cause "and" gates 409, 411, and 413 to selectively
13 activate blocks 429, 427, 425. Blocks 429, 427, and 425 are coupled to block
14 433 which is linked by data bus 402 to software filter 149. When block 429
15 receives a high input, the variable held in the memory location "target restore
16 count" is moved to a memory location identified as "align hold". When block
17 427 receives a high input signal, the value held in the memory location
18 identified as "underblown count" is moved to a memory value identified as
19 "align hold". When block 425 receives a high input signal, the numeric value
20 held in a memory location identified as "overblown count" is moved to a
21 memory location identified as "align hold". As stated above, block 433
22 performs a continuous asynchronous "push" operation, and will push any
23 value identified to the "align hold" memory location to the values of SAMPLE
24 (N), SAMPLE (N-1), and BPE in the software filter of Figure 23. In the
25 preferred embodiment of the present invention, the value of "overblown count"
26 is set to correspond to the distance between reference R and maximum
27 circumference threshold B which is depicted in Figure 16, which is
28 established distance at which the control system will determine that an
29 "overblown" condition exists. Also, in the preferred embodiment of the
30 present invention, the value of the "underblown" count will be set to a
31 minimum circumference threshold C, which is depicted in Figure 16, and

1 which corresponds to the detection of an underblown condition. Also, in the
2 present invention, the value of "target restore count" is preferably established
3 to correspond to the value of set point A, which is depicted in Figure 16, and
4 which corresponds generally to the distance between reference R and the
5 imaginary cylinder established by the position of the sizing cage with respect
6 to the blown film tube.

7
8 Figure 23A is a flowchart of the preferred filtering process
9 applied to CURRENT POSITION signal generated by the acoustic transducer.
10 Preferably, it includes multiple stages of filtering, for different operating
11 conditions. The first stage of filtering pertains to relatively unstable operating
12 conditions. The second stage of filtering pertains to relatively stable operating
13 conditions. The digitized CURRENT POSITION signal is provided from
14 analog to digital converter 141 to software filter 149. The program reads the
15 CURRENT POSITION signal in step 161. Then, the software filter 149 sets
16 SAMPLE (N) to the position signal.

17
18 In step 165, the absolute value of the difference between CURRENT
19 POSITION (SAMPLE (N)) and the previous sample (SAMPLE (N - 1)) is
20 compared to a first threshold. If the absolute value of the difference between
21 the current sample and the previous sample is less than first threshold T1,
22 the value of SAMPLE (N) is set to CFS, the current filtered sample, in step
23 167. If the absolute value of the difference between the current sample and
24 the previous sample exceeds first threshold T1, in step 169, the CURRENT
25 POSITION signal is disregarded, and the previous position signal SAMPLE
26 (N - 1) is substituted in its place.

27
28 Then, in step 171, the suggested change SC is calculated, by
29 determining the difference between the current filtered sample CFS and the
30 best position estimate BPE. In step 173, the suggested change SC which
31 was calculated in step 171 is compared to positive T2, which is the maximum

1 limit on the rate of change. If the suggested change is within the maximum
2 limit allowed, in step 177, allowed change AC is set to the suggested change
3 SC value. If, however, in step 173, the suggested change exceeds the
4 maximum limit allowed on the rate of change, in step 175, the allowed
5 change is set to +LT2, a default value for allowed change.

6
7 In step 179, the suggested change SC is compared to the
8 negative limit for allowable rates of change, negative T2. If the suggested
9 change SC is greater than the maximum limit on negative change, in step
10 181, allowed change AC is set to negative -LT2, a default value for negative
11 change. However, if in step 179 it is determined that suggested change SC
12 is within the maximum limit allowed on negative change, in step 183, the
13 allowed change AC is added to the current best position estimate BPE, in
14 step 183. Finally, in step 185, the newly calculated best position estimate
15 BPE is written to the PI loop program.

16
17 Software filter 149 is a two stage filter which first screens the
18 CURRENT POSITION signal by comparing the amount of change, either
19 positive or negative, to threshold T1. If the CURRENT POSITION signal, as
20 compared to the preceding position signal exceeds the threshold of T1, the
21 current position signal is discarded, and the previous position signal
22 (SAMPLE (N - 1)) is used instead. At the end of the first stage, in step 171,
23 a suggested change SC value is derived by subtracting the best position
24 estimate BPE from the current filtered sample CFS.

25
26 In the second stage of filtering, the suggested change SC value
27 is compared to positive and negative change thresholds (in steps 173 and
28 179). If the positive or negative change thresholds are violated, the allowable
29 change is set to a preselected value, either +LT2, or -LT2. Of course, if the
30 suggested change SC is within the limits set by positive T2 and negative T2,
31 then the allowable change AC is set to the suggested change SC.

1 As is shown in Figure 23A, data bus 201 couples the emergency
2 condition control logic block 150 to software filter 149. As stated above,
3 emergency condition control logic block 150 is designed to asynchronously
4 push a numeric value identified in the memory location of "speed hold" to LT2
5 in software filter 149. Furthermore, emergency condition control logic block
6 150 will asynchronously push a numeric value in the memory location
7 identified as "ALIGN HOLD" to SAMPLE (N), SAMPLE (N - 1), and BPE. As
8 stated above, SAMPLE N corresponds to the current position signal as
9 detected by the transducer. SAMPLE (N - 1) corresponds to the previous
10 position signal as determined by the transducer. BPE corresponds to the
11 best position estimate.

12
13 Since the operation of emergency condition control mode logic
14 block 150 is asynchronous, block 186 of Figure 23A should be read and
15 understood as corresponding to an asynchronous read function. Therefore,
16 at all times, as set forth in block 186, software filter 149 receives values of
17 "speed hold" and "align hold" from emergency condition control mode logic
18 block 150, and immediately substitutes them into the various logic blocks found
19 in software filter 149. For example, SAMPLE (N) is found in logic blocks 163,
20 165, and 167. SAMPLE (N - 1) is found in logic blocks 165, and 169. BPE
21 is found at logic block 183. The program function represented by block 186
22 operates to asynchronously and immediately push the values of "speed hold"
23 and "align hold" to these various functional blocks, since OVERBLOWN,
24 UNDERBLOWN, and lost TARGET conditions can occur at any time.

25
26 The normal operation of software filter 149 may also be
27 understood with reference to Figure 24, and will be contrasted with examples
28 of the emergency condition mode of operation as depicted in Figures 25, 26,
29 and 27. In the graph of Figure 24, the y-axis represents the signal level, and
30 the x-axis represents time. The signal as sensed by acoustic transducer 79
31 is designated as input, and shown in the solid line. The operation of the first

1 stage of the software filter 149 is depicted by the current filtered sample CFS,
2 which is shown in the graph by cross-marks. As shown, the current filtered
3 sample CFS operates to ignore large positive or negative changes in the
4 position signal, and will only change when the position signal seems to have
5 stabilized for a short interval. Therefore, when changes occur in the current
6 filtered sample CFS, they occur in a plateau-like manner.

7
8 In stage two of the software filter 149, the current filtered sample
9 CFS is compared to the best position estimate BPE, to derive a suggested
10 change SC value. The suggested SC is then compared to positive and
11 negative thresholds to calculate an allowable change AC which is then added
12 to the best position estimate BPE. Figure 24 shows that the best position
13 estimate BPE signal only gradually changes in response to an upward drift
14 in the POSITION SIGNAL. The software filtering system 149 of the present
15 invention renders the control apparatus relatively unaffected by random noise,
16 but capable of tracking the more "gradual" changes in bubble position.

17
18 Experimentation has revealed that the software filtering system of the
19 present invention operates best when the position of extruded film tube 81 is
20 sampled between 20 to 30 times per second. At this sampling rate, one is
21 less likely to incorrectly identify noise as a change in circumference of
22 extruded film tube 81. The preferred sampling rate accounts for the common
23 noise signals encountered in blown film extrusion liner.

24
25 Optional thresholds have also been derived through
26 experimentation. In the first stage of filtering, threshold T1 is established as
27 roughly one percent of the operating range of acoustic transducer 79, which
28 in the preferred embodiment is twenty-one meters (24 inches less 3 inches).
29 In the second stage of filter, thresholds +LT2 and -LT2 are established as
30 roughly 0.30% of the operating range of acoustic transducer 79.

1 Figure 25A is a graphic depiction of the control system response
2 to the detection of an UNDERBLOWN condition. The X-axis of the graph of
3 Figure 25A is representative of time in seconds, and the Y-axis of the graph
4 of Figure 25A is representative of position in units of voltage counts. A graph
5 of the best position estimate BPE is identified by dashed line 503. A graph
6 of the actual position of the extruded film tube with respect to the reference
7 position R is indicated by solid line 501. On this graph, line 505 is indicative
8 of the boundary established for determining whether the blown film tube is in
9 an "underblown" condition. Line 507 is provided as an indication of the normal
10 position of the blown film tube. Line 509 is provided to establish a boundary
11 for determining when a blown film tube is considered to be in an "overblown"
12 condition.

13
14 The activities represented in the graph of Figure 25A may be
15 coordinated with the graph of Figure 25B, which has an X-axis which is
16 representative of time in seconds, and a Y-axis which represents the binary
17 condition of the TARGET signal, and the UNDERBLOWN signal, as well as
18 the output of block 421 of Figure 22, which is representative of the output of
19 the time out filter realignment software clock. Now, with simultaneous
20 reference to Figures 25A and 25B, segment 511 of the best position estimate
21 indicates that for some reason the best position estimate generated by
22 software filter 149 is lagging substantially behind the actual position of the
23 blown film tube. As shown in Figure 25A, both the actual and estimated
24 position of the blown film tube are in an underblown condition, which is
25 represented in the graph of Figure 25B.

26
27 As stated above, in connection with Figure 22 and the
28 discussion of the operation of the emergency condition control logic block
29 150, the locking software loop which is established by anticipation state "or"
30 gate 403 and "and" gate 419 will lock the output of anticipation state "or" gate
31 403 to a high condition. Therefore, next-state "or" gate 415 is awaiting the

1 change in condition of any of the following signals: the OVERBLOWN signal,
2 the UNDERBLOWN signal, and the TARGET signal. As shown in Figure
3 25A, at a time of 6.5 seconds, the actual position of the blown film tube
4 comes within the boundary 505 established for the underblown condition,
5 causing the output of next-state "or" gate 415 to go high, which causes the
6 output of inverter 417 to go low, which causes the output of "and" gate 419
7 to go low. This change in state also starts the software timer of block 421,
8 and causes block 427 to push the value of "underblown count" to the "align
9 hold" variable. Also, simultaneously, software block 423 pushes the value of
10 "quick filter align" to the "speed hold" variable. The values of "speed hold"
11 and "underblown count" are automatically pushed to block 433. Meanwhile,
12 the software timer of block 421 overrides the normal and continuous pushing
13 of "normal filter align" to the "speed hold" variable for a period three seconds.
14 The three second period expires at 9.5 seconds.

15
16 Thus, for the three second time interval 513, software filter 149
17 is allowed to respond more rapidly to change than during normal operating
18 conditions. As shown in Figure 22, block 433 operates to automatically and
19 asynchronously push the value of "speed hold" to "LT2" in software filter 149.
20 Simultaneously, block 433 operates to continuously, automatically, and
21 asynchronously push the value of "align hold" to SAMPLE (N), SAMPLE (N-1)
22 and BPE in software filter 149. This overriding of the normal operation of
23 software filter 149 for a three second interval allows the software best position
24 estimate 503 to catch up with the actual position 501 of the blown film tube.
25 The jump represented by segment 515 in the best position estimate 503 of
26 the blown film tube is representative of the setting of SAMPLE (N), SAMPLE
27 (N-1) and BPE to the "underblown count" which is held in the "align hold"
28 variable. Segment 517 of the best position estimate 503 represents the more
29 rapid rate of change allowable during the three second interval, and depicts
30 the best position estimate line 503 tracking the actual position line 501 for a
31 brief interval. At the expiration of the three second interval, software filter 149

1 of the control system returns to a normal mode of operation which does not
2 allow such rapid change in the best position estimate.

3
4 Figures 26A and 26b provide an alternative example of the
5 operation of the emergency condition control mode of operation of the present
6 invention. In this example, the TARGET signal represented in segment 525
7 of Figure 26b is erroneously indicating that the blown film tube is out of range
8 of the transducer. Therefore, segment 529 of dashed line 527 indicates that
9 the best position estimate according to software filter 149 is set at a default
10 constant value indicative of the blown film tube being out of range of the
11 transducer, and is thus far from indicative of the actual position which is
12 indicated by line 531. This condition may occur when the blown film tube is
13 highly unstable so that the interrogating pulses from the transducer are
14 deflected, preventing sensing of the blown film tube by the transducer.
15 Segment 533 of Figure 26b is representative of stabilization of the blown film
16 tube and transition of the TARGET signal from an "off" state to an "on" state.
17 This transition triggers initiation of the three second software timer which is
18 depicted by segment 535. The time period begins at 12.5 seconds and ends
19 at 15.5 seconds. The transition of the TARGET signal from a low to a high
20 condition triggers the pushing of the "target restore count" value to the "align
21 hold" variable, as is graphically depicted by segment 537. During the three
22 second interval, the best position estimate established by software filter 149
23 is allowed to change at a rate which is established by the "quick filter align"
24 value which is pushed to the "speed hold" variable and bused to software
25 filter 149. At the termination of the three second interval, the software filter
26 149 returns to normal operation.

27
28 Figure 27A provides yet another example of the operation of the
29 emergency condition control mode. Segment 541 of Figure 27B indicates
30 that the TARGET signal is in a low condition, indicating that the blown film
31 tube is out of range of the transducer. Segment 543 indicates that the blown

1 film tube has come into range of the transducer, and the TARGET signal
2 goes from a low to a high condition. Simultaneous with the movement of the
3 blown film tube into range of the transducer, the UNDERBLOWN signal goes
4 from a low to a high condition indicating that the blown film tube is in an
5 underblown condition. Segment 545 of Figure 27B indicates a transition from
6 a high UNDERBLOWN signal to a low UNDERBLOWN signal, which
7 indicates that the blown film tube is no longer in an underblown condition.
8 This transition initiates the three second interval which allows for more rapid
9 adjustment of the best position estimate.

10
11 The foregoing description related to the first stage of filtering which is
12 especially useful during relatively unstable operating conditions, wherein
13 overblown and underblown extruded film tube conditions are possible. The
14 second stage of filtering, which will now be described, pertains to relatively
15 stable operating conditions, when the extruded film tube is in a substantially
16 fixed position. This type of filtering is preferably a dynamic filtering operation,
17 in which the influence of the dynamic filter is increased or decreased,
18 depending upon at least one pre-established criterion. Preferably, the
19 criterion comprises a comparison of the output of the filtering operation with
20 the current bubble position. If there is a great difference between the
21 detected extruded film tube position and the output of the filter, the operating
22 assumption is that the extruded film tube is perhaps becoming unstable, and
23 the influence of the dynamic filtering operation should be reduced. Converse-
24 ly, if the difference between the output of the dynamic filtering process and
25 the current position of the extruded film tube is small or decreasing, the
26 assumption is made that the extruded film tube is in a relatively stable
27 operating condition, and the influence of the dynamic filtering operation
28 should be increased. In the present invention, the dynamic filtering operation
29 comprises a rolling average of detected position signals, with the number of
30 samples utilized to calculate the rolling average increasing if stability is

1 detected and decreasing if instability is detected. The foregoing will become
2 clear with reference to Figures 28A, 28B, 28C, 28D, 28E, 28F, and 28G.

3 With reference to Figure 23A, the basic filtering operation is depicted
4 in flowchart form. At the termination of software step 183, a best position
5 estimate (BPE) is calculated. The process continues at software block 184(a)
6 of Figure 23B, wherein the best position estimate is provided. Next, in
7 accordance with software block 184(b), it is determined whether or not an
8 alarm condition exists; if an alarm condition exists, the process continues at
9 software block 184(c), wherein the process continues by going to block 185
10 of Figure 23A; if, however, it is determined in software block 184(b) that there
11 is no alarm condition, the process continues. In software block 184(d), the
12 processor determines whether or not the extruded film tube is in a startup
13 mode of operation; if so, the process continues at software block 184(e) by
14 passing control to software block 185 in Figure 23A; however, if it is deter-
15 mined in software block 184(d) that the bubble is not a startup mode of
16 operation, the process continues. In software block 184(f), the controller
17 determines whether or not there is an ongoing change in extruded film tube
18 balance; if so, the process continues at software block 184(g) by passing
19 control to software block 185 in Figure 23A. However, if it is determined in
20 software block 184(f) that there is no ongoing change in extruded film tube
21 balance, the process continues. In accordance with software block 184(h),
22 the controller determines whether the extruded film tube (or "bubble") has
23 been stable for sixty continuous seconds; if not, the process continues at
24 software block 184(i), wherein control is passed to software block 185 in
25 Figure 23A; however, if it is determined in software block 184(h) that the
26 bubble has been stable for sixty continuous seconds, then control is passed
27 to software block 184(j), wherein the dynamic filter of Figure 23C is utilized
28 to process the position signals during this relatively stable interval of
29 operation.

30 In broad overview, the basic filtering operation of Figure 23A alone is
31 performed if any one of a variety of indicators reveal that stable operation is

1 not ongoing or is unlikely. A variety of the rudimentary indicators are
2 identified in Figure 23B, and various other indicators can be devised which
3 can be added to the items in Figure 23B which provide further screening
4 which prevents the dynamic filtering operation from commencing.

5 Once relatively stable operations are ongoing, the dynamic filtering
6 operation may be applied. The preferred embodiment of the dynamic filtering
7 operation is depicted in block diagram form in Figure 23C. As is shown, the
8 process continues at software block 184(k), wherein the best position
9 estimate is provided as an input to a rolling average generator 184(l) which
10 computes a rolling average from a number of previous samples of the best
11 position estimate (BPE), preferably based upon the following formula:

12
$$RA = RA + ((BPE - RA_{prev}) \div (Sample\ Number))$$

13 wherein

14 RA is the rolling average;
15 RA_{prev} is previous rolling average;
16 BPE is the best position estimate currently provided; and
17 Sample Number is a number which determines the number of
18 samples utilized to calculate the rolling average
19
20
21

22 The output of rolling average generator 184(l) is subtracted from the
23 input to the rolling average generator 184(l), which is the best position
24 estimate (BPE). This defines an "ERROR". This is provided as an input to
25 the number of samples calculator 184(m), which calculates the number of
26 samples based upon the ERROR (which is input), a predetermined GAIN
27 value, and a BIAS value in accordance with the following formula:

28
$$SAMPLE\ NUMBER = (ERROR \times GAIN) + BIAS$$

29 The BIAS 184(n) is a manufacturer-configurable variable which helps
30 to determine the span (or range) of available sample numbers utilized in
31 determining the rolling average. The output of the number of samples
32 calculator 184(m) is provided as an input to software block 184(o), which
33 pushes the Sample Number to the rolling average generator 184(l) every
second.

1 In accordance with present invention, the values for ERROR, GAIN
2 and BIAS are selected to insure that, during very stable operations, the rolling
3 average generator 184(l) utilizes ten (10) previous samples of the best
4 position estimate (BPE) in order to calculate the rolling average. If the
5 difference between the input to the rolling average generator 184(l) and the
6 output of the rolling average generator 184(l) increases, the number of
7 samples calculator 184(m) reduces the number of samples utilized by the
8 rolling average generator 184(l). When the difference (ERROR) is at its
9 greatest (and most unacceptable) level, the number of samples calculator
10 184(m) reduces the number of samples to unity (1), therefore causing the
11 input of the rolling average generator 184(l) to be provided as the output of
12 rolling average generator 184(l) without any dynamic filtering whatsoever. In
13 other words, as the ERROR increases, the influence of the rolling average
14 generator 184(l) is incrementally decreased from its maximum influence to its
15 minimum influence, which essentially bypasses the dynamic filtering operation
16 altogether.

17 As is shown in Figure 23C, the output of the rolling average generator
18 184(l) is supplied to software block 184(p), which sets the BPE to the output
19 of the rolling average generator 184(l). Then, in accordance with 184(q),
20 controls return to software block 185 of Figure 23A.

21 The beneficial influence of the dynamic filtering operation can best be
22 understood with reference to Figures 23D and 23E. Figure 23D is a graphi-
23 cally depiction of the bubble position 184(r) and the valve position 184(s) with
24 respect to time, without dynamic filtering. As is shown, the valve position
25 moves in direct correspondence with the bubble position, quite dynamically.
26 Figure 23E is a graphical depiction of bubble position 184(t) and the output
27 of the rolling average generator 184(u), as well as valve position 184(v), all
28 with respect to time. As is shown, the rolling average generator is much
29 more stable than the detected bubble position (BPE). The extreme positive
30 and negative peaks of the bubble position (BPE) are eliminated through the
31 dynamic filtering process, making the control system altogether less

1 susceptible to noise and meaningless bubble flutter than without the dynamic
2 filtering process. As is shown in Figure 23(E), the valve (or other flow control
3 device) is basically controlled by the output of the rolling average generator,
4 and is also much less susceptible to the noise or bubble flutter. This type of
5 noise is a common problem in particularly stiff materials, such as nylon.

6 Figure 23F is a graphical depiction of a frequency distribution compari-
7 son of the dynamically filtered position signal shown in single cross-hatching
8 and the unfiltered position signal (BPE) shown in double cross-hatching. This
9 frequency distribution reveals that there is about a 33% reduction in the stan-
10 dard deviation between the dynamically filtered position signal and the fil-
11 tered, but not dynamically filtered, position signal. In the real world, this
12 relates to about a 2 millimeter reduction in lay flat variation, which reduces a
13 6 millimeter total variation to about a 4 millimeter total variation. This greatly
14 increases the control system's performance during these relatively stable
15 operating intervals.

16 Figure 23G is a graphical depiction of startup operations with the
17 dynamic filter in place. The X-axis represents time and the Y-axis represents
18 the valve position 184(w), the bubble position 184(x), the output of the rolling
19 average generator 184(y). As is shown, the dynamic filtering operation is not
20 active until time 184(z), after which the prerequisite stability has been
21 obtained. It is at that point that the position of the valve 184(w) is directly
22 controlled through the rolling average generator. Note the greater stability of
23 valve position once the rolling average generator has been activated.

24 Figure 28 is a schematic and block diagram representation of an
25 airflow circuit for use in a blown film extrusion system. Input blower 613 is
26 provided to provide a supply of air which is routed into airflow circuit 611.
27 The air is received by conduit 615 and directed to airflow control device 617
28 of the present invention. Airflow control device 617 operates as a substitute
29 for a conventional rotary-type airflow valve 631, which is depicted in simplified
30 form also in Figure 28. The preferred airflow control device 617 of the
31 present invention is employed to increase and decrease the flow of air to

1 supply distributor box 619 which provides an air supply to annular die 621
2 from which blown film tube 623 extends upward. Air is removed from the
3 interior of blown film tube 623 by exhaust distributor box 625 which routes the
4 air to conduit 627, and eventually to exhaust blower 629.

5
6 The preferred airflow control device 617 is depicted in
7 fragmentary longitudinal section view in Figure 29. As is shown, airflow
8 control device 617 includes housing 635 which defines inlet 637 and outlet
9 639 and airflow pathway 641 through housing 635. A plurality of selectively
10 expandable flow restriction members 671 are provided within housing 635 in
11 airflow pathway 641. In the view of Figure 29, selectively-expandable flow
12 restriction members 673, 675, 677, 679, and 681 are depicted. Other
13 selectively-expandable flow restriction members are obscured in the view of
14 Figure 29. Manifold 685 is provided to route pressurized air to the interior of
15 selectively-expandable flow restriction members 671, and includes conduit
16 683 which couples to a plurality of hoses, such as hoses 687, 689, 691, 693,
17 695 which are depicted in Figure 29 (other hoses are obscured in Figure 29).

18
19
20 Each of the plurality of selectively-expandable flow restriction
21 members includes an inner air-tight bladder constructed of an expandable
22 material such as an elastomeric material. The expandable bladder is
23 surrounded by an expandable and contractible metal assembly. Preferably,
24 each of the plurality of selective-expandable flow restriction members is
25 substantially oval in cross-section view (such as the view of Figure 29), and
26 traverse airflow pathway 641 across the entire width of airflow pathway 641.
27 Air flows over and under each of the plurality of selectively-expandable airflow
28 restriction members, and each of them operates as an choke to increase and
29 decrease the flow of air through housing 635 as they are expanded and
30 contracted. However, the flow restriction is accomplished without creating

1 turbulence in the airflow, since the selectively-actuable flow restriction
2 members are foil shaped.

3
4 Returning now to Figure 28, airflow control device 617 is
5 coupled to proportional valve 657 which receives either a current or voltage
6 control signal and selectively vents pressurized fluid to airflow control device
7 617. In the preferred embodiment, proportional valve 657 is manufactured
8 by Proportion Air of McCordsville, Indiana. Supply 651 provides a source of
9 pressurized air which is routed through pressure regulator 653 which
10 maintains the pressurized air at a constant 30 pounds per square inch of
11 pressure. The regulated air is directed through filter 655 to remove dust and
12 other particulate matter, and then through proportional valve 657 to airflow
13 control device 617.

14
15 In the preferred embodiment of the present invention, airflow
16 control device 617 is manufactured by Tek-Air Systems, Inc. of Northvale,
17 New Jersey, and is identified as a "Connor Model No. PRD Pneumavalve".
18 This valve is the subject matter of at least two U.S. patents, including U.S.
19 Patent No. 3,011,518, which issued in December of 1961 to Day et al., and
20 U.S. Patent No. 3,593,645, which issued on July 20, 1971, to Day et al.,
21 which was assigned to Connor Engineering Corporation of Danbury,
22 Connecticut, and which is entitled "Terminal Outlet for Air Distribution", both
23 of which are incorporated herein by reference as if fully set forth.

24
25 Experiments have revealed that this type of airflow control
26 device provides for greater control than can be provided by rotary type valve
27 631 (depicted in Figure 28 for comparison purposes only), and is especially
28 good at providing control in mismatched load situations which would ordinarily
29 be difficult to control economically with a rotary type valve.

1 A number of airflow control devices like airflow control device
2 617 can be easily coupled together in either series or parallel arrangement
3 to control the total volume of air provided to a blown film line or to allow
4 economical load matching. In Figure 28, a series and a parallel coupling of
5 airflow control devices is depicted in phantom, with airflow control devices
6 681, 683, and 685 coupled together with airflow control device 617. As
7 shown in the detail airflow control device 617 is in parallel with airflow control
8 device 683 but is in series communication with airflow control device 685.
9 Airflow control device 685 is in parallel communication with airflow control
10 device 681. Airflow control devices 681 and 683 are in series
11 communication.

12
13 The present invention is also directed to a method and
14 apparatus for cooling extruded film tubes, which utilizes a mass air flow
15 sensor to provide a measure of the flow of air in terms of both the air density
16 and air flow rate. The mass air flow sensor provides a numerical value which
17 is indicative of the mass air flow in an air flow path within a blown film
18 extrusion system. A controller is provided for receiving the measure of mass
19 air flow from the mass air flow sensor and for providing a control signal to an
20 adjustable air flow attribute modifier which serves to selectively modify the
21 mass air flow in terms of mass per unit time by typically changing one or
22 more of the cooling air temperature, the cooling air humidity, or the cooling
23 air velocity. The preferred method and apparatus for cooling extrude film
24 tubes is depicted and described in detail in Figures 30 through 36, and the
25 accompanying text.

26
27 The particular type of mass air flow sensor utilized in the present
28 invention makes practical the utilization of mass air flow values in blown film
29 extrusion systems. Of course, "mass air flow" is simply the total density of
30 the cooling air or gas multiplied times the flow rate of the cooling air or gas.
31 Typically, blown film extrusion lines utilize ambient air for cooling and/or

1 sizing the molten blown film tube as it emerges from the annular die. It may
2 become economically practical in the future to utilize gases other than
3 ambient air; for purposes of clarity and simplicity, in this detailed description
4 and the claims, the term "air" is intended to comprehend both ambient air as
5 well as specially provided gases or gas mixtures.

6
7 While it is simple to state what the "mass air flow" represents,
8 it is far more difficult to calculate utilizing conventional techniques. This is
9 true because of the difficulty associated with calculating the density of air. Air
10 which contains water vapor requires the following information for the accurate
11 calculation of "mass air flow": the relative humidity of the air, the absolute
12 pressure of the air, the temperature of the air, the saturation vapor pressure
13 for the air at the given temperature, the partial pressure of the water vapor at
14 the given temperature, the specific gravity of the air, and the flow rate of the
15 air. Utilizing conventional sensors, one could easily measure relative
16 humidity, temperature of the air, absolute pressure, and the flow rate of the
17 air. With established data tables correlating the temperature of the gas and
18 the relative humidity, the saturation vapor pressure and the partial pressure
19 of the water vapor can be calculated. For ambient air applications, the
20 specific gravity of the gas is unity so it drops out of consideration. A good
21 overview of the complexity associated with the calculation of these factors
22 which make up the "mass air flow" is provided in a book entitled *Fan*
23 *Engineering: An Engineers Handbook On Fans And Their Applications*, edited
24 by Robert Jorgensen, 8th edition, which is published by Buffalo Forge
25 Company of Buffalo, New York. While such calculations are not particularly
26 difficult given modern technologies for both sensors and data processors, the
27 utilization of a single sensor which provides a direct indication of the "mass
28 air flow" lessens the costs associated with implementation of the method and
29 apparatus for cooling extruded film tubes of the present invention. Such use
30 of a mass air flow sensor also reduces the complexity associated with
31 calculating mass air flow utilizing a more conventional technique. This can

1 be seen by comparing the calculations required for a system which does not
2 utilize a mass air flow sensor, with one which does utilize a mass air flow
3 sensor. The "mass flow rate" of air is determined by equation 1.1 which is
4 set forth here below:

5 Equation 1.1

$$6 \quad \text{Mass Flow Rate} = \text{Density} * \text{Flow Rate}$$

7
8 Of course, the flow rate is easy to obtain from flow rate meters,
9 but the density of the cooling air must be determined in accordance with
10 equation 1.2 which is set forth here below:

11 Equation 1.2

$$\text{Density} = \frac{((P - P_{ws}\phi) + P_{ws}\phi\omega)}{.7543(T + 459.7)}$$

12
13
14 wherein P is representative of the absolute pressure of the air, Pws is
15 representative of the saturation vapor pressure, ϕ is representative of the
16 relative humidity, and ω is representative of the ratio of the density of the
17 water vapor to the density of dry air, and T is representative of the
18 temperature of the cooling air in degrees F. Since we measure P, ϕ , and T
19 directly, we only have to derive Pws and ω . By using a saturation vapor
20 pressures table of water, we can determine the saturation vapor pressure
21 (Pws) from the temperature of the cooling air. The following equation 1.3
22 allows one to calculate ω , which is the ratio of the water vapor density to dry
23 air density:

24 Equation 1.3

$$\omega = 1.6214 + \frac{\phi(P_{ws})^{1/1.42}}{1130}$$

1 This formula is accurate to 0.1% in the range of temperatures from 32°F to 400°F.

2 Therefore, it is evident that, in addition to a velocity sensor, sensors
3 must be provided for the measurement of pressure, relative humidity, and
4 temperature. Additionally, the saturation vapor pressure and the ratio of the density
5 of water vapor to the density of dry air must be calculated utilizing a provided table,
6 which in microprocessor implementations must be represented by a data array
7 maintained in memory. All together, the complexity and opportunity for error
8 presented by such an array of sensors and series of calculations and table look-up
9 operations renders this technique difficult and expensive to implement.

10 In contrast, the present invention for cooling extruded tubes utilizes a
11 single sensor which provides a direct measurement of the mass air flow. Such
12 mass air flow sensors have found their principle application in internal combustion
13 engines, and are described and claimed in the following issued United States
14 Patents, each of which is incorporated herein by reference as if fully set forth:

- 15 (1) U.S. Patent No. 4,366,704, to Sato et al., entitled Air Intake Apparatus
16 For Internal Combustion Engine, which issued on January 4, 1983, and
17 which is owned by Hitachi, LTD., of Tokyo, Japan;
- 18 (2) U.S. Patent No. 4,517,837, to Oyama et al., entitled Air Flow Rate
19 Measuring Apparatus, which issued on May 21, 1985, and which is
20 owned by Hitachi, LTD., of Tokyo, Japan;
- 21 (3) U.S. Patent No. 5,048,327, to Atwood, entitled Mass Air Flow Meter,
22 which issued on September 17, 1991;

1 (4) U.S. Patent No. 5,179,858, to Atwood, entitled Mass Air Flow Meter
2 which issued on January 19, 1993.
3

4 Mass air flow sensors operate generally as follows. One or more
5 (typically platinum) resistor elements are provided in an air flow path way. An
6 energizing current is provided to the one or more resistor elements. Air passing
7 over the resistor elements reduces the temperature of the resistor elements. A
8 control circuit is provided which maintains currents at a constant amount in
9 accordance with King's Principal.

10 For the particular mass air flow sensor utilized in the preferred
11 embodiment of the present invention, the mass air flow of the air flowing through an
12 air pathway within a blown film extrusion system is established in accordance with
13 equation 1.4 as follows:

14 Equation 1.4

15 Mass Flow Rate = **al.601** (sensor reading+offset)^c

16 wherein the constants are attributable to the specific construction of the
17 sensor assembly.

18 In accordance with the present invention, a mass air flow sensor is
19 utilized to control air flow to cool molten polymers when extruded in a thin film tube.
20 The air flow may be provided in contact with either an interior surface of the thin film
21 tube, an exterior surface of the thin film tube, or both an interior surface of the thin
22 film tube and an exterior surface of the thin film tube. The air flow amount must be
23 consistent in order to maintain the desired cooling rate of the polymer. Changes in

1 the cooling rate modify the extent to which polymer chains are formed, linked, and
2 cross-linked. Under the prior art, the cooling air is at best controlled to a constant
3 temperature. There is no consideration in prior art systems to the changes in the
4 heat removing capacity of the air as the air gets more or less humid, or as the
5 absolute pressure changes. Changes in the barometric pressure of one inch of
6 mercury can change the mass air flow rate by 3.3%. Changes in the temperature
7 in the air typically have the greatest effect on the heat removing capacity of the
8 cooling air, with a 10% change in relative humidity causing a tenth of 1% change in
9 mass air flow rate. It is estimated that utilization of the present invention in blown
10 film extrusion lines which have temperature control will add an additional accuracy
11 in cooling up to 3.5%. For blown film extrusion lines which do not have temperature
12 control, the consistency in cooling can be improved by an amount estimated at 13%
13 to 15% provided physical limits of the attribute modifying equipment are not reached.

14 Cooling efficiency of course influences the production rate which can
15 be obtained blown film extrusion lines. Generally speaking, it is desirable to have
16 the extruded molten material change in state from a molten state to a solid state
17 before the blown film tube travels a predetermined distance from the annular die.
18 In the industry, the location of the state change is identified as the "frost line" in a
19 blown film tube. In the prior art, when big changes occur in the temperature,
20 humidity, or barometric pressure, the frost line of the extruded film tube may move
21 upward or downward relative to a desired location. This may cause the operator of
22 the blown film line to decrease production volumes in order to keep from
23 jeopardizing product quality, since product quality is in part determined by the

1 position or location of the frost line. While utilization of the present invention
2 improves the cooling of extruded film tubes, the present invention also can be
3 utilized to compensate for changes in the mass air flow rate of the cooling gas
4 supplied to the interior of a blown film tube and the hot exhaust gas drawn from the
5 blown film tube, to provide essentially a constant frost line height, or at least a frost
6 line height that does not move because of changes in the mass air flow rate. Of
7 course, the present invention can be utilized in combination with prior art external
8 cooling devices for blown film extrusion lines to provide the same benefit.

9 So considered broadly, the present invention can be utilized to
10 accomplish a number of desirable results, including:

11 (1) it can be used as a frost line leveler for blown film extrusion line with
12 external air cooling only;

13 (2) it can be used in both the supply and exhaust systems of an internal-
14 bubble-cooling blown film extrusion system to manage and maintain a balanced air
15 flow between the supply and exhaust, which could greatly stabilize the position of
16 the frost line insofar as changes in the ambient temperature, humidity, and
17 barometric pressure effect the position of the frost line; this could eliminate the need
18 for prior art frost line location sensors;

19 (3) the mass air flow sensor can be utilized in combination with the
20 controller or computer to determine the most effective and efficient operating range
21 of flow pump devices such as blowers, and fans, by allowing the computer to
22 determine the mass air flow rate with relation to blower speed (and valve position)
23 and then systematically eliminate undesirable ranges of operation, which are

1 generally found at the lowest and highest ends of the operating range, where the
2 flow pump or valve may perform in a non-linear fashion which would introduce
3 unstable characteristics into the operation of the blown film line;

4 (4) the mass air flow sensor can be utilized to provide a rather slow feed
5 back signal to a supply blower in the blown film line, to compensate for changes in
6 the ambient air, such as temperature, humidity, and barometric pressure, which
7 effect the mass air flow rate;

8 (5) the mass air flow sensor can be used to provide a feed back loop
9 which enhances the operation of a flow control valve in the line, to ensure that the
10 valve operation is providing a particular air flow characteristic in response to a
11 particular valve activation signal.

12 In the following detailed description, Figures 30 and 31 are directed to
13 a blown film extrusion system which includes an internal cooling air flow and an
14 external cooling air flow. In contrast, the detailed description relating to Figures 32
15 through 35 are directed to a more simple blown film extrusion system which includes
16 only an external cooling air flow.

17 With reference first to Figure 30, there is depicted an internal-bubble-
18 cooling blown film extrusion line 701 in schematic form. As is shown, blown film
19 tube 703 is extruded from annular die 705. An ultrasonic transducer 707 is utilized
20 to gage the position of blown film tube 703, and provides a control signal to position
21 processor 709, all of which has been discussed in detail in this detailed description.
22 A sizing cage 711 is provided to size and stabilize the blown film tube 703. A flow
23 of internal cooling air is supplied to the interior of blown film tube 703 through supply

1 stack 713. As is conventional, exhaust stack 717 is also provided in an interior
2 position within blown film tube 703 for removing the cooling air from the interior of
3 blown film tube 703. A cooling air is supplied to supply stack 713 through supply
4 distributor box 715, and the exhausted air is removed from blown film tube 703
5 through exhaust distributor box 719. Additionally, an external cooling air ring 721
6 is provided for directing a cooling stream of air to an exterior surface of blown film
7 tube 703. Cooling air ring 721 collaborates with the internal cooling air stream to
8 change the state of the molten material from a molten state to a solid state. Cooling
9 air ring 721 is provided with entrained ambient air from air ring blower 723 which
10 may be set tot a flow rate either manually or automatically.

11 Supply distributor box 715 is provided with an entrained stream of
12 cooling air in the following manner. Ambient air is entrained by the operation of
13 supply blower 729. It is received at input filter 725, and passed through (optional)
14 manual damper 727. If supply blower 729 is a variable-speed-drive type of supply
15 blower, then manual damper 727 is not required. Preferably, however, supply
16 blower 729 is a variable speed drive controller which provides a selected amount of
17 air flow in response to a command received at a control input of variable-speed-drive
18 731. Also, preferably, variable speed drive controller is optionally subject to
19 synchronous command signals from IBC controller 753 which controls the general
20 operations of the blown film extrusion line. The entrained ambient air is routed
21 through air flow path 755, first through cooling system 733, which preferably
22 includes a plurality of heat exchange coils and heat transference medium in
23 communication with the air flow, which receives a circulating heat exchange medium

1 (such as chilled water for transferring heat), past mass air flow sensor 737, through
2 air flow control device 739 (such as that depicted and described in connection with
3 Figures 28 and 29 above), and through supply distributor box 715. Mass air flow
4 sensor 737 provides a voltage signal which is indicative of the mass air flow of the
5 air flowing through air flow path 755 in the region between cooling system 733 and
6 air flow control device 739. Air flow control device 739 operates in response to
7 proportional valve 741 and selectively receives compressed air from compressed air
8 supply 743. Air flow control device 739 includes a plurality of members which may
9 be expanded and contracted to enlarge or reduce the air flow path way through he
10 housing of air flow control device. This allows for the matching of loads, as is
11 discussed above in connection with Figures 28 and 29. Proportional valve 741 is
12 under the control of IBC controller 753.

13 Exhaust distributor box 719 removes cooling air from blown film tube
14 703 and routes it through damper 745, into air flow path 755. The air passes
15 through mass air flow sensor 747 which provides a voltage which is indicative of the
16 mass air flow of the exhaust from blown film tube 703. The air is pulled from air
17 flow path 755 by the operation of exhaust blower 749 which is responsive to an
18 operator command, preferably through a variable speed drive 751, which is also
19 preferably under the synchronous control command of IBC controller 753.

20 In broad overview, mass air flow sensor 737 provides an indication of
21 the mass air flow of the cooling air which is supplied through supply distributor box
22 715 to supply stack 713. This cooling air removes heat from blown film tube 703,
23 helping it change from a molten state to a solid state. Mass air flow sensor 747 is

1 in communication with the exhaust air removed through exhaust stack 717 and
2 exhaust distributor box 719. Mass air flow sensor 747 provides a voltage which is
3 indicative of the mass air flow of the exhaust cooling air. The measurements
4 provided by mass air flow sensors 737,747 are supplied to a controller which
5 includes a microprocessor component for executing preprogrammed instructions.

6 In accordance with the present invention, IBC controller 753
7 compares the values from mass air flow sensors, 737, 747 and then provides
8 command controls to variable speed drives 731, 751 in order to effect the operation
9 of supply blower 729 and/or exhaust blower 749. Preferably, IBC
10 controller 753 may be utilized in response to an operator command to maintain
11 supply blower 729 and/or exhaust blower 749 at a particular level or magnitude of
12 blower operation, or to provide a particular ratio of blower operation, so that when
13 the temperature, humidity, or barometric pressure of the ambient air changes
14 significantly, the blowers adjust the flow rate of the input cooling air and exhaust
15 cooling air to blown film tube 703 to maintain uniformity of heat absorbing capacity
16 of the internal cooling air, notwithstanding the change in temperature, humidity,
17 and/or barometric pressure.

18 The operation of this rather simple feed back loop is set forth in
19 flowchart form in Figure 36. The process starts at software block 771, and
20 continues at software block 773, wherein IBC controller 753 receives an operator
21 command from either an operator interface 757 on IBC controller 753, or an operator
22 interface 759 on variable speed drive 731. Next, values provided by mass air flow
23 sensors 737 and 747 are recorded in memory, in accordance with software block

1 775. Then in accordance with step 777, operation set points are derived. For
2 example, a particular ratio between the mass air flow detected at mass air flow
3 sensor 737 and mass air flow sensor 747 may be derived. Then, in accordance with
4 step 779, IBC controller 75 monitors signals from mass air flow sensors 737 and 747
5 for changes in mass air flow, which are principally due to changes in the ambient
6 temperature, humidity, and barometric pressure. Once a change is detected, in
7 accordance with step 781 IBC controller 753 synchronously adjusts the variable
8 speed drives 759, 731, 751 in order to affect the value of the mass air flow of
9 ambient air which has been entrained and which is flowing through air flow passage
10 way 755 in a manner which returns operation to the set point values derived in step
11 777. For example, variable speed drive 731, 751 may be utilized to increase or
12 decrease the volume of air entrained by supply blower 729 and/or exhausted by
13 exhaust blower 749. In accordance with step 783, this process is repeated until an
14 additional operator command is received. Such commands may include an
15 instruction to obtain a new operation set point, or to discontinue the feed back loop
16 until instructed otherwise. A cooling coil 738 may also be provided in
17 communication with air flow path 745, and may be adjusted in response to IBC
18 controller 753 to adjust the value of mass air flow.

19 Figure 31 depicts an alternative to the embodiment of Figure 30
20 wherein mass air flow sensors are utilized to control both the internal cooling air
21 supply to the interior of blown film tube 703 and an external cooling air stream which
22 is supplied to the exterior surface of blown film tube 703 from air ring 721. The
23 figures differ in that, in addition of having a control system for internal cooling air,

1 a control system for external cooling air is also provided with a mass air flow sensor
2 747 positioned in air flow path 741 between air ring blower 723 and cooling air ring
3 721. Mass air flow sensor 747 provides a measurement of the mass air flow of the
4 air flowing within air flow path 745. This measurement is provided to IBC controller
5 753 and compared to a set point value which has been either manually entered by
6 the operator at operator interface 757 or which has been automatically obtained in
7 response to an operator command made at operator interface 757. IBC controller
8 753 supplies a control signal to variable speed drive 744 which is utilized to adjust
9 the operating condition of air ring blower either upward or downward in order to
10 maintain the established set point. If the mass air flow sensor 747 indicates to IBC
11 controller 753 that the total mass air flow has been diminished (perhaps due to
12 changes in temperature, humidity, and barometric pressure), then IBC controller 753
13 may supply a command signal to variable speed drive 744 which increases the
14 throughput of air ring blower 723 in a manner which compensates for the
15 diminishment in mass air flow as detected by mass air flow sensor 747. If mass air
16 flow sensor 747 detects an increase in the mass air flow, IBC controller 753 may
17 provide a command signal to variable speed drive 744 which increases the
18 throughput of air ring blower 723 in a manner which compensates for the
19 diminishment in mass air flow a detected by mass air flow sensor 747. If mass air
20 flow sensor 747 detects an increase in the mass air flow, IBC controller 753 may
21 provide a command signal to variable speed drive 744 which reduces the throughput
22 of air ring blower 723, thus diminishing the amount of mass air flow in order to make
23 it equal to the set point maintained in memory in response to an operator command.

1 This simple feedback loop is also characterized by the flowchart depiction in Figure
2 36. Since changes in ambient temperature, ambient humidity, and barometric
3 pressure are rather slow, it is not necessary that this feedback loop be a very fast
4 loop. It is sufficient that every few minutes the value for the mass air flow sensor
5 be monitored to determine the numeric value of the mass air flow, that this value be
6 compared to a set point recorded in memory, and that an appropriate command be
7 provided to blower in order to adjust the mass air flow upward or downward to make
8 it equivalent to the set point value. This allows a program which implement the
9 present invention to be "piggy backed" onto the IBC controller 753. The calculations
10 required to compare mass air flow values to set points is trivial and these operations
11 need only be performed every few minutes, so the IBC controller can spend the vast
12 majority of its computational power of controlling the blown film line, with only a de
13 minimis portion expended to occasional checking and adjusting of the mass air flow.
14 Additionally, a cooling coil 74 may be provided in communication with air flow path
15 745, and may be provided in communication with air flow path 745, and may be
16 adjusted in response to IBC controller 753 to adjust the value of mass air flow.

17 The present invention can also be utilized in far simpler blow film
18 extrusion systems which utilize only external cooling air to remove heat from a
19 molten blown film tube. Four particular embodiments are depicted in Figures 32, 33,
20 34, and 35. In each of these embodiments, a mass air flow sensor is positioned
21 intermediate and external cooling air ring and a blower for entraining and supplying
22 air to the cooling ring. Additionally an adjustable air flow attribute modifier is
23 provided in the air flow path for selectively modifying the air mass per unit time.

1 This adjustable air flow attribute modifier may comprise any mechanism for adjusting
2 for modifying the mass air flow, but in particular will most probably comprise a
3 cooling coil system which chills the cooling air, or an air flow control device which
4 restricts or enlarges the quantity of air available for entrainment by the supply
5 blower, or a fluid injection system which modifies the humidity of the cooling air.
6 Each of these three principle alternative embodiments will be discussed in detail
7 herebelow in connection with Figures 32, 33, 34, and 35.

8 Turning first to Figure 32, an external cooling blown film extrusion line
9 is depicted in schematic form. Plastic pellets are loaded into resin hopper 791,
10 passed through heating apparatus 793, and driven by extruder 795 through die 797
11 to form a molten extruded film tube 789, with a portion of the extruded film tube 789
12 below frost line 801 being in a molten state, and that portion above frost line 801
13 being in a solid state. Air ring 799 is positioned adjacent die 797 and adapted to
14 route cooling air along the exterior surface of blown film tube 789. Air ring 799 is
15 supplied with cooling air which is entrained by air ring blower 803, routed through
16 cooling coils 805 of cooling system 809, and through mass air flow sensor 807.
17 Preferably, mass air flow sensor 807 is positioned in air flow path 821 intermediate
18 cooling coils 805 and external cooling air ring 799. Cooling coils 805 are adapted
19 to receive chilled water 813 from chiller system 811. Controller 815 is provided for
20 receiving a signal from mass air flow sensor 807 which is indicative of the mass air
21 flow of the cooling air flowing through air flow path 821, and for providing a
22 command signal to chiller system 811 which adjusts the temperature of chilled water
23 813 which is routed through cooling coil 805. A feed back loop is established about

1 a set point selected by the operator when a set point selection command button 817
2 is depressed. Controller 815 will respond to the command by recording in memory
3 the mass air flow value provided by mass air flow sensor 807, and by adjusting the
4 chiller system 811 upward or downward in temperature in order to maintain the
5 mass air flow value of cooling air flowing through air flow path 821 at a value
6 established by the set point. Of course, the operator has an operator interface for
7 chiller system 811 which allows for the operator setting of the temperature of chiller
8 system 811. This system works once the operator has established that sufficient
9 cooling has been obtained, and should provide an equivalent level of cooling from
10 the external cooling air provided by air ring 799 even though the ambient air
11 changes its density through relatively slow changes in temperature, humidity, and
12 barometric pressure. The embodiment of Figure 32 is especially suited for blown
13 film extrusion lines which have a dedicated chiller system. The embodiment of
14 Figure 33 depicts a more common scenario, wherein a single chiller system is
15 shared by multiple blown film lines. In this event, the configuration differs insofar as
16 chiller system 811 is utilized to provide chilled water 813 for delivery to multiple heat
17 exchange cooling coils, with a flow valve, such as flow valve 825, being provided of
18 each set of heat exchange cooling coils to increase or decrease the flow o
19 circulating heat exchange fluid in order to alter the temperature of the cooling air in
20 air flow path 821. In the embodiment depicted in Figure 33, controller 815 provides
21 an electrical command signal to an electrically-actuated flow valve 825 in order to
22 increase or decrease the flow of chilled water 813 from chiller system 811 to cooling
23 coil 805. Similar to the embodiment of Figure 32, the operator instructs controller

1 815 to record the mass air flow value from mass air flow sensor 807, and to utilize
2 that as a set point for operation. Thereafter, changes in the mass air flow property
3 of the cooling air passing through air flow path 821, such as changes caused by
4 changes in temperature, humidity, and barometric pressure, are accommodated by
5 increasing or diminishing the flow of chilled water from chiller system 811 to heat
6 exchange cooling coil 805. Increases in mass air flow will result in the controller 815
7 providing a command to electrically-actuated flow valve 825 to diminish the flow of
8 chilled water; in contrast, decreases in mass air flow as detected by mass air flow
9 sensor 807 will result in controller 815 providing a command signal to electrically-
10 actuated flow valve 825 to increase the flow of chilled water from chiller system 811
11 to heat exchange cooling coils 805.

12 Figure 34 is a schematic depiction of an external air blown film
13 extrusion line, with blown film tube 789 extending upward from die 797 and being
14 cooled by an air stream in contact with an exterior surface of blown film tube 789
15 which is provided by air flow path 821. Air flow path 821 includes mass air flow
16 sensor 807 which provides a numerical indication of the mass air flow of the air
17 passing through air flow path 821. It provides this numerical indication to controller
18 815, which in turn supplies a command signal to either variable speed controller 831
19 or air flow control device 833 (such as that depicted in Figures 28 & 29 above), each
20 of which can effect the volume of air which is entrained by air ring blower 803.
21 Controller 815 includes a manual control 817 which is utilized by the operator to
22 establish a set point of operation. Typically, the operator will get the blown film line
23 operating in an acceptable condition, and then will actuate the set point command

1 817, causing controller 815 to record in memory the value provided by mass air flow
2 sensor 807. Thereafter, changes in the mass air flow due to changes in tempera-
3 ture, humidity, or barometric pressure will be compensated for by variation in the
4 amount of air entrained by air ring blower 803, in order to maintain mass air flow
5 value at or about the set point value. For example, if the mass air flow value
6 decreases, as determined by the mass air flow sensor 807, variable speed controller
7 831 or air flow control device 833 are provided with command signals from controller
8 815 to increase the volume of air flowing through air flow path 821; however, if the
9 mass air flow value increases, as determined by mass air flow sensor 807, controller
10 815 provides a command signal to either variable speed controller 831 or air flow
11 control device 833 in order to decrease the volume of air entrained by air ring blower
12 803. In this manner, controller 815 may intermittently check the value of the mass
13 air flow, compare it to a set point value recorded in memory, and adjust the volume
14 of air entrained by air ring blower 803 in order to maintain a mass air flow value at
15 or about the set point. In this manner, the cooling ability the air stream in contact
16 with the exterior of extruded film tube 789 is maintained at a constant level
17 notwithstanding gradual or dramatic changes in temperature, humidity, and
18 barometric pressure.

19 Figure 35 depicts yet another embodiment of the invention, wherein an
20 external cooling blown film extrusion line is depicted in the schematic form, with
21 extruded film tube 789 extending upward from annular die 797, which is cooled by
22 an air stream provided by cooling air ring 799. Cooling air ring 799 receives its
23 cooling air from air flow path 821. Mass air flow sensor 807 is positioned in air flow

1 path 821, and is adapted to provide a signal indicative of the mass air flow of air
2 flowing through this passage way, to controller 815. Controller 815 provides a
3 command signal to water injector 835 which is also in communication with the air
4 passing through air flow path 821. Water injector 835 is adapted to increase the
5 humidity of the air entrained by blower 803 in response to a command from control-
6 ler 815. In accordance with this embodiment of this invention, the operator
7 depresses a set point control 817 on controller 815 in order to establish a set point
8 o operation for controller 815. Controller 815 records in memory the value of mass
9 air flow sensor 807, and thereafter continuously monitors the values provided by
10 mass air flow sensor 807 in comparison to the set point. When an increase in mass
11 air flow is required, controller 815 provides a command signal to water injector 835
12 which provides a predetermined amount of moisture which is immediately absorbed
13 by the air entrained by air ring blower 803. When no additional humidity is required,
14 controller 815 will no provide such a command. In this manner, the mass air flow
15 value for air entrained in air flow path 821 may be moderated by operation of
16 controller 815. Since this system easily allows an increase in the mass air flow
17 value, without allowing a corresponding decrease in the mass air flow value, it is
18 particularly useful in very hot and dry climates.

19 In all embodiments, it is advisable to provide a predetermined time
20 interval of time interval of monitoring before the set point is recorded and
21 established. This allows the operator to make changes in the operating condition
22 of the various blowers and other equipment in the blown film line prior to requesting
23 that a set point be established. It takes many minutes (5, 10, or 20 minutes) in

1 order for the system to reach a quiescent condition of operation. Having a
2 predefined interval of time after request for a set point, during which the mass air
3 flow values are monitored but not recorded, allows the operator to change the
4 operating state of the blown film line, and request a set point value, at the same
5 time, without obtaining a set point value which is perhaps not stable or quiescent.
6 In yet another more particular embodiment of the present invention, the controller
7 may be programmed to monitor the rate of change of the mass air flow value for
8 predetermined time interval in order to determine for itself that a quiescent condition
9 has been obtained. For example, a 10 or 20 minute interval may be provided after
10 operator request of a set point, during which the controller continuously polls the
11 mass air flow sensor, calculates a rate of change for a finite time interval, and
12 records it in memory. Only when the rate of change reaches an acceptable level
13 will the controller determine that a quiescent interval has been obtained, and
14 thereafter record the mass air flow value in memory for utilization as a set point, or
15 in the derivation of a set point, about which the feedback loop is established.

16
17 **Figure 37A** is a pictorial and schematic representation of the prior art
18 technique for controlling an extruded film tube during startup operations. In the prior
19 art, a linear ratio controller is utilized by a human operator in order to determine and
20 set the balance condition of a supply blower and an exhaust blower in a blown film
21 extrusion apparatus. The prior art operates by utilizing human-set potentiometers
22 in order to balance the supply component **1003**, load component **1005**, and the
23 exhaust component **1007** in a linear ratio controller **1001**. Determining the balance
24 condition of a supply blower and an exhaust in a blown film extrusion apparatus is
25 complicated by the fact that the blowers are non-linear. This is graphically depicted

1 in **Figures 37B** and **37C**. **Figure 37B** is a graph **1009** of the response curve **1015**
2 of a supply blower, with the X-axis **1011** representative of the air flow in units of
3 cubic feet per minute, and the Y-axis **1013** representative of pressure in inches of
4 water. As is shown in **Figure 37B**, the response curve **1015** is not linear. **Figure**
5 **37C** is a graph **1017** of the response curve **1023** of an exhaust blower, with the X-
6 axis **1019** representative of air flow in cubic feet per minute, and the Y-axis **1021**
7 representative of pressure in inches of water. As is clear from **Figure 37C**, the
8 response curve **1023** of the exhaust blower is not linear.

9
10 **Figure 37D** is a schematic and block diagram representation of the startup
11 control apparatus **1030** of the present invention. As is shown, a die **1033** receives
12 molten material and extrudes film tube **1031**. Air is supplied to the interior of
13 extruded film tube **1031** via supply inlet **1035**, and air is exhausted from extruded
14 film tube **1031** through exhaust outlet **137**. During production operations, a balance
15 between the supply and exhaust must be maintained (in fact, the balance is slightly
16 biased toward supply) in order to maintain the extruded film tube **1031** at a predeter-
17 mined and substantially constant circumference. As is shown in **Figure 37D**, supply
18 blower **1037** communicates through air flow pathway **1036** to supply air to the
19 interior of extruded film tube **1031**. In accordance with the preferred embodiment
20 of the present invention, valve member **1034** is provided within air flow pathway
21 **1036** in order to provide for adjustment of the supply in order to allow for fine control
22 over the circumference of the extruded film tube **1031**, as has been discussed in
23 detail above. Valve **1034** may comprise a rotary valve (as discussed above) or an
24 air flow control member which includes selectively-expandable flow restriction
25 members (also as discussed above). Exhaust blower **1039** communicates with the
26 interior of extruded film tube **1031** through air flow pathway **1038**. Supply blower
27 **1037** and exhaust blower **1039** are under the control of variable speed drive **1041**
28 and variable speed drive **1043** through control lines **1045**, **1047**. Supply control
29 signals are directed to supply blower **1037** via control line **1045** to increase or
30 decrease its output. Likewise, exhaust control signals are directed via exhaust
31 control line **1047** to exhaust blower **1039** in order to increase or decrease its output.

1 In accordance with the present invention, variable speed drives **1041**, **1043** are
2 under control of controller **1077**.

3
4 Controller **1077** communicates with variable speed drive **1041** through
5 stop/start line **1051** which stops/starts variable speed drive **1041**, flow matching
6 signal **1053** which communicates a control signal to variable speed drive **1041**,
7 actual speed line **1055** which provides an indication of the actual speed of supply
8 blower **1037** to controller **1077**, and OK switch **1049** which communicates through
9 lines **1057**, **1059** to controller **1077** which provides a signal to controller **1077** when
10 variable speed drive **1041** is operating correctly.

11
12 Controller **1077** communicates with variable speed drive **1043** through
13 stop/start line **1063** which provides a stop or start signal to variable speed drive
14 **1043**, actual speed line **1065** which provides an indication of the actual speed of
15 exhaust blower **1039** to controller **1077**, and master IBC signal **1067** which com-
16 municates through master speed reference **1071** (which is an operator-adjustable
17 potentiometer) which provides operator input to controller **1077** regarding the
18 operating conditions of the supply blower **1077** and exhaust blower **1039** during
19 startup operations. Additionally, controller **1037** is provided with a status indication
20 via lines **1073**, **1079** and switch **1061** which provides an indication of the operating
21 condition of variable speed drive **1043**.

22
23 Controller **1077** communicates with control panel **1079** which provides data
24 to the operator, and which allows for operator input and commands. Control panel
25 **1079** includes inlet on/off switch **1083** and outlet on/out switch **1085** which allow the
26 operator to stop and start the supply blower **1037** and exhaust blower **1039**.
27 Preferably, control panel **1079** also includes manual blower input means **1091** which
28 allows for manual control of the blowers. Additionally, control panel **1079** includes
29 a blower balance display **1087** and master speed display **1089**. Preferably, and
30 additionally, control panel **1079** includes decrease button **1090**, and increase button
31 **1092**, which allow the operator to manually adjust either or both the supplier blower

1 **1037** and exhaust blower **1039** during certain operations (but in the preferred
2 embodiment, just the supply blower), as will be discussed in detail below.

3
4 The startup control apparatus **1030** of the present invention allows the
5 operator to efficiently stabilize the extruded film tube by automatically coordinating
6 the flow rate of the supply blower **1045** with the flow rate of the exhaust blower
7 **1047**. The startup control apparatus **1030** provides a special startup feature that
8 minimizes the need to establish a separate setup of startup settings. Compensation
9 for non-linear blower curves is managed by a combination of learned settings and
10 an efficient means to verify the learned settings are still accurate. The startup
11 control apparatus **1030** also includes a bubble break detector that allows the option
12 of stopping the production line when a bubble break occurs. In accordance with the
13 present invention, the startup control apparatus **1030** monitors the status of each of
14 the supply blower **1045** and exhaust blower **1047** and uses such status to manage
15 startup and shutdown.

16
17 **Figure 37E** is a flowchart representation of some of the routines utilized
18 during startup procedures. The process begins at software block **1100** and con-
19 tinues at software block **1101**, wherein controller **1077** determines whether a startup
20 mode of operation has been selected; if so, control passes to software block **1103**,
21 wherein the startup procedure of **Figure 37F(1)** through **37F(2)** is performed. If it
22 is determined in software **1101** that the startup mode has not been selected, control
23 passes to software block **1105**, wherein controller **1077** determines whether the run
24 mode has been selected; if the run mode has been selected, control passes to soft-
25 ware block **1107**, where controller **1077** performs the run procedures of **Figures**
26 **37G** through **37J**. If it is determined in software block **1105** that the run mode has
27 not been selected, control passes to software block **1109**, which determines whether
28 the balance mode of operation has been selected. If the balance mode of operation
29 has been selected, control passes to software block **1111**, wherein controller **1077**
30 performs the balance procedure of **Figure 37K**. If it is determined in software block

1 1109 that the balance mode has not been selected, control passes to software block
2 1113, where the process ends.

3
4 Turning now to **Figures 37F(1) and 37F(2)**, the startup mode will be
5 explained with reference to the flowchart. The process begins at software block
6 1121 and continues at software block 1123, wherein the operator activates the inlet
7 blower. Next, in accordance with software block 1125, controller 1077 fetches a
8 start percent parameter which is recorded in memory. In accordance with the pre-
9 ferred embodiment of the present invention, the start percent parameter is a prede-
10 termined percentage of the value of the master speed control displayed on master
11 speed display 1089 (of **Figure 37D**). In accordance with software block 1127,
12 controller 1077 sends control signals through variable speed drive 1041 to supply
13 blower 1037 in order to ramp supply blower 1037 up to the start percent parameter.
14 In accordance with the present invention, a predetermined ramping function 1128
15 is stored in memory of controller 1077 which provides a bumpless ramp function
16 which is followed in the ramping up of supply blower 1037. In the preferred
17 embodiment of the present invention, the ramp function is non-linear to improve the
18 blower response and to reduce the chance of overshooting the start percent value.
19 An example of the ramp function 1128 is depicted adjacent software block 1127.

20
21 Next, in accordance with software block 1129, controller 1077
22 deactivates an outlet blower stop circuit in order to allow exhaust blower 1039 to
23 start up. Next, in accordance with software blocks 1131 and 1133, controller 1077
24 determines whether the operator has adjusted the master speed reference potenti-
25 ometer 1071 (of **Figure 37D**). If so, the inlet blower is adjusted in accordance with
26 software block 1133. The process continues at software block 1135, wherein the
27 operator determines that the extruded film tube (or "bubble") is through the roller
28 nips (as is depicted in **Figure 1**). Next, in accordance with software block 1137, the
29 operator activates the exhaust blower 1039 by actuating outlet on/off switch 1085.
30 Next, in accordance with software block 1139, controller 1077 ramps the exhaust
31 blower 1039 (through a predetermined ramping function 1140, which is preferably

1 linear) to the full-rated value of the master speed reference potentiometer **1071** (of
2 **Figure 37D**). Controller **1077** then monitors the speeds of the supply blower **1037**
3 and the exhaust blower **1039** in order to determine if the speeds are substantially
4 equal, as set forth in software block **1141**. If the speeds are not equal, monitoring
5 and comparing operations continue. If it is determined in software block **1141** that
6 the speeds of the supply blower and the exhaust blower are equal, control passes
7 to software block **1143**, wherein the inlet blower is ramped (again, in accordance
8 with a predetermined function **1144** which is preferably non-linear) to the full-rated
9 value of the master speed reference potentiometer **1071** (of **Figure 37D**) as dis-
10 played on master speed display **1089** (also of **Figure 37D**). Next, in accordance
11 with software block **1145**, controller **1077** monitors the position of the extruded film
12 tube. Next, and in accordance with software block **1147**, controller **1077** determines
13 whether the extruded film tube is within range of a predetermined sensor (preferably,
14 the cage sensor). If the extruded film tube is not within range, control passes back
15 to software block **1145**; however, if the extruded film tube is within a predetermined
16 range, control passes to software block **1149**, wherein controller **1077** is utilized to
17 adjust the supply blower **1037** to place the valve **1036** in the middle of its linear
18 operating range.
19

20 In accordance with the present invention, valve **1036** may comprise
21 either a rotary valve or the "bladder" valve discussed above. Each of these valves
22 has a preferred and substantially linear operating range, but the valves are generally
23 not linear over their entire operating range. Therefore, in accordance with the
24 present invention, the linear operating range of a particular valve might be
25 determined empirically in a laboratory, and controller **1077** will be programmed to
26 maintain the valve in its relatively linear operating range. When a "bladder" valve
27 is utilized, that linear range represents a closure condition in the range of 28% to
28 32%. Operation outside of that narrow range of closure conditions would be less
29 than optimal. Since valve **1036** is utilized for fine control over the circumference of
30 the extruded film tube, it is relatively important that the valve be operated over its
31 optimal and linear range of operation. This will allow for better control of the

1 extruded film tube during production operations which follow startup, and which have
2 a significant impact on the product quality produced by the blown film line and the
3 product quantity produced by the blown film line. Optimization of the valve will be
4 discussed in greater detail below. The process then ends at software block **1151**.

5
6 The run mode of operation is depicted in flowchart form commencing at
7 **Figure 37G**. The process commences in software block **1161**, and continues at
8 software block **1163**, wherein controller **1077** calls the blower balance routine for
9 execution. In broad overview, the controller **1077** works to balance the supply and
10 exhaust blowers **1037**, **1039** by first looking for a recorded value for the operating
11 condition and associated supply blower setting from the last time the system was
12 running. In accordance with the present invention, a plurality of values for prior
13 production runs are stored in memory for use during the run mode of operation. An
14 array of such recorded historical run settings is depicted in simplified form in **Figure**
15 **37L**. As is shown, three columns are recorded, including the master speed potenti-
16 ometer setting **1301**, supply speed **1303**, and reference volts **1305**. For each
17 master speed potentiometer setting available, there is possibly a corresponding
18 recorded historical value of supply speed **1303** and its associated reference voltage
19 **1305**. Several dozen to several hundred historical values may be recorded. These
20 values represent prior optimum settings of the supply blower **1037** for different
21 operating conditions. Since these particular settings were used in prior production
22 runs, it is presumed that they were satisfactory settings. In order to increase the
23 efficiency and accuracy of startup procedures, controller **1077** will first look to
24 historical and recorded values, if those values exist.

25
26 Returning now to **Figure 37G**, the process continues to software block **1165**,
27 wherein controller **1077** determines whether a blower balance startup history exists.
28 In other words, controller **1077** determines whether there are any prior historical and
29 recorded values for the setting of supply blower **1037**. If not, control passes to
30 software block **1167**, and the process ends at software block **1169**. However, if it
31 is determined that a history does exist, control passes to software block **1171**,

1 wherein controller **1077** examines the blower balancing startup history to determine
2 whether there is a value which has been recorded for the current operating condition
3 as set by the master speed potentiometer setting. If no particular historical value
4 corresponds to the current settings, then control passes to software block **1173**, and
5 the process ends at software block **1175**. However, if it is determined that a prior
6 recorded historical value exists for the operating condition of the supply blower
7 **1037**, control passes to software block **1177**, and the process ends at software block
8 **1179**.

9
10 **Figure 37H** is a flowchart representation of software block **1167** of **Figure**
11 **37G**. This routine is executed if a blower balance startup history exists. The
12 process being at software block **1201**, and continues to software block **1203**,
13 wherein controller **1077**
14 examines the position of valve **1034** (of **Figure 37D**). Next, in accordance with
15 software block **1205**, controller **1077** determines whether valve **1034** is within its 28-
16 32% state of closure. As discussed above, this range represents the optimum and
17 linear operating range of a "bladder" valve which is described herein. If it is
18 determined in software block **1205** by controller **1077** that valve **1034** is within its
19 optimum range of operation, the process ends at software block **1211**. However,
20 if it is determined in software block **1205** that valve **1034** is not within its optimum
21 and linear operating range, the particular percentage of closure is examined to
22 determine whether it falls above or below the 28-32% range. If the closure state is
23 greater than 30%, control passes to software block **1027**, wherein the operating rate
24 of supply blower **1037** is increased by a predetermined amount. Control will then
25 pass back to software block **1205** in order to reexamine the operating condition of
26 valve **1034**. If it is determined at software block **1205** that valve **1034** is below 28%
27 closure, control passes to software block **1209** wherein the rate of operation of
28 supply blower **1037** is decreased by a predetermined amount. Control would then
29 return to software block **1205** in order to allow for reexamination of the operating
30 condition of valve **1034**. This process will repeat until valve **1034** is placed within
31 its optimum and substantially linear operating state.

1
2 **Figure 37I** is a flowchart representation of software block **1173** of **Figure**
3 **37G**. This routine corresponds to a situation wherein a blower balance startup his-
4 tory does exist, but no recorded and historical value exists which directly corres-
5 ponds to the current setting established for the blown film extrusion line. The
6 process begins at software block **1221**, and continues at software block **1223**,
7 wherein controller **1077** fetches the operating speed for the supply blower **1037** from
8 a linear model. Function **1220** is a graphical representation of such a linear model
9 which maps values of the master speed potentiometer setting to supply speeds (or
10 the reference voltages which correspond to the supply speeds). The model is a
11 simple function ($y = mx$). The model value which corresponds to the current speed
12 potentiometer setting is then applied to supply blower **1037**. Next, in accordance
13 with software block **1225**, controller **1077** examines the position of valve **1034** to
14 determine its current state. Then, control passes to software block **1227**, wherein
15 controller **1077** is utilized to determined whether valve **1034** is within its optimum
16 and substantially linear operating range of 28% to 32% (for the "bladder" type valve
17 discussed above). If the valve **1034** is operating within its optimum and substantially
18 linear operating range, control passes to software block **1233**, wherein the process
19 ends. However, if it is determined in software block **1227** that valve **1034** is not
20 within its preferred operating range, the closure state of the valve is examined to
21 determine whether it falls above or below the preferred operating range. If the
22 closure is greater than 32%, control passes to software block **1229** wherein the
23 operating condition of supply blower **1037** is decreased by a non-linear offset
24 component which is depicted by function **1222** (in the preferred embodiment, a pre-
25 determined constant is added to the previous function in order to generate a function
26 of $y = mx + b$). If it is determined in software block **1229** that the valve is operating
27 below the 28% closure condition, control passes to software block **1231**, wherein the
28 operation of supply blower **1037** is increased by a non-linear offset component (in
29 this situation, and in the preferred embodiment of the present invention, a constant
30 term is added to the previous function in order to utilize a function of $y = mx - b$).

1 This process is repeated until the valve **1034** is placed in its optimum range of
2 operation.

3
4 **Figure 37J** is a flowchart representation of software block **1177** of **Figure**
5 **37G**. In this situation, controller **1077** has determined that a blower balance startup
6 history does exist, and that there is a value in the historical log which directly
7 corresponds to the current master speed potentiometer setting. The process begins
8 at software block **1241** and continues at software block **1243**, wherein controller
9 **1077** utilizes the last recorded value for the operating condition of supply blower
10 **1037**. Then, in accordance with software block **1245**, the controller determines
11 whether the extruded film tube (or "bubble") is at its proper size. Next, in accord-
12 ance with software block **1247**, controller **1077** determines whether the recorded
13 value which is utilized for establishing the setting of supply blower **1037** places valve
14 **1034** within its optimum range of operation (which, in the preferred embodiment for
15 "bladder" type valves, is 28% to 32%). If it is determined in software **1247** that valve
16 **1034** is not operating in its preferred range of positions, control passes to software
17 block **1249**, and the process ends at software block **1251**. However, if it is deter-
18 mined in software block **1247** that the valve is indeed operating within its preferred
19 range of positions, control passes to software block **1253**, wherein the balance mode
20 is not entered, and the process ends at software block **1255**.

21
22 **Figure 37K** is a flowchart representation of software block **1249** of **Figure**
23 **37J**, and describes the balance mode of operation in accordance with the preferred
24 embodiment of the present invention. The balance mode of operation is entered if
25 the historical recorded value for the setting of supply blower **1037** does not place the
26 valve in its preferred range of operation. The purpose of the balance mode of opera-
27 tion is to allow the operator to obtain direct control over the operating condition of
28 supply blower **1034**. In the balance mode of operation, the position of valve **134** is
29 locked to 30%. In control panel **1079**, a ratio is displayed which represents the ratio
30 of the running speeds of the supply blower **1037** and the exhaust blower **1039**. An
31 indication of 50% means that both blowers are running at the same speed. An indi-

1 cation greater than 50% means that the supply blower is running faster than the
2 exhaust blower (which is the normal condition). An indication of less than 50%
3 means that the supply blower is running slower than the exhaust blower. The
4 operator can manually adjust the balance by using buttons **1097**, **1092** (of **Figure**
5 **37D**). Selecting the negative button will cause the supply blower to slow down.
6

7 With reference to **Figure 37K**, the process commences at software block
8 **1261** and continues at software block **1263**, wherein controller **1077** locks the valve
9 position to 30%. Next, in accordance with software block **1265**, control panel **1079**
10 is utilized to display the "relative ratio" number. Then, in accordance with software
11 block **1067**, controller **1077** monitors for operator input through depression of either
12 the negative button **1090** or the positive button **1092**. In software block **1269**, con-
13 troller **1077** monitors for selection of the negative button. If the negative button is
14 selected, control passes to software block **1271**, wherein the supply blower is
15 slowed down. In accordance with software block **1273**, controller **1077** monitors for
16 selection of the positive button. If the positive button is selected, control passes to
17 software block **1275**, wherein the supply blower is speeded up. In accordance with
18 software block **1277**, controller **1077** monitors for selection of a production mode of
19 operation by the operator. If the production mode is selected, in accordance with
20 software block **1279**, controller **1077** records the setting in memory (in the table of
21 **Figure 37L**) and the process ends at software block **1281**.
22

23 **Figure 37M** is a flowchart representation of a bubble break routine which is
24 utilized after the initial steps of startup have been concluded in order to detect
25 bubble break or collapse, sound an alarm, and optionally shut down the blown film
26 line. The bubble break detection routine is suppressed during early phases of the
27 startup in order to allow the operator to get the bubble started. The process
28 commences at software block **1321**, wherein the bubble break routine is called for
29 execution. Next, in accordance with software block **1323**, controller **1077** deter-
30 mines whether the blown film line is operational, and the exhaust blower is in an on
31 condition. In this way, the bubble break routine is suppressed until the operator

1 manually activates the exhaust blower. In accordance with software block **1325**,
2 controller **1077** starts a timer delay (which is operator-configurable in the range of
3 1-10 minutes) which allows an amount of time sufficient for the operator to get the
4 blown film line started. In accordance with software block **1327**, controller **1077**
5 monitors the bubble position sensor in order to determine the location of the bubble.
6 In accordance with software block **1329**, the bubble position sensor is monitored to
7 determine whether there is a loss of signal. If no signal loss occurs, control returns
8 to software block **1327**. However, if the position sensor signal is lost, control passes
9 to software block **1331**, wherein a software timer is initiated. Then, in accordance
10 with software block **1333**, controller **1077** determines whether the signal is still gone.
11 If not, control passes to software block **1327**. If so, control passes to software block
12 **1339**, wherein controller **1077** determines whether the second software timer has
13 "timed out". If not, control returns to software block **1333**; if so, control passes to
14 software block **1337**, where an alarm is sounded. Alternatively, and concurrently
15 with the sounding of the alarm, the blown film line may be disabled. The routine
16 ends at software block **1339**. In accordance with the present invention, controller
17 **1077** is utilized to continuously monitor the condition of the exhaust blower
18 throughout the entire process. Any change in condition of the exhaust blower will
19 automatically reset the bubble break detection routine to its initial condition. In this
20 manner, the bubble break routine will only run after the operator has been provided
21 with a sufficient time in which to get the extruded film tube within the nips, but only
22 becomes operational if the exhaust blower has been activated. Once the position
23 signal has been lost for a sufficiently long time interval, the bubble break detector
24 will at least sound an alarm in order to warn of likely break or collapse of the bubble.
25 Since the system automatically resets itself upon any change in condition of the
26 exhaust blower, it will become initialized for the next startup.

27
28 Although the invention has been described with reference to a specific
29 embodiment, this description is not meant to be construed in a limiting sense.
30 Various modifications of the disclosed embodiment as well as alternative embod-
31 iments of the invention will become apparent to persons skilled in the art upon

1 reference to the description of the invention. It is therefore contemplated that the
2 appended claims will cover any such modifications or embodiments that fall within
3 the true scope of the invention.
4
5